

Garant

GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e8 DC/ R1: 20/4,0mm



Order data

Order number	206255 20/4,0
GTIN	4062406156336
Item class	11X

Description

Version:

Cutting edge length to DIN 6527.

All dimensions to DIN.

Tolerance: Corner radius $R_1 = \pm 0.01$ mm.

Application:

Especially for **high speed machining** in **mould and tool making** for **copy milling**.

Technical description

No. of teeth Z	3
Overhang length L_1 incl. recess	52 mm
Cutting edge $\varnothing D_c$	20 mm
Helix angle	42 degrees
Balance quality with shank	G 2.5 with HA
Shank	DIN 6535 HA to h6
Overall length L	104 mm
Shank $\varnothing D_s$	20 mm
Feed f_z for side milling in short-chipping aluminium	0.22 mm
Feed f_z for copy milling in short-chipping aluminium	0.25 mm
Corner radius R_1	4 mm

Flute length L_c	41 mm
Recess $\varnothing D_1$	19.8 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Tolerance nominal \varnothing	e8
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	0.5×D for side milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PMMA acrylic	suitable	200 m/min	N
PE-HD	suitable	160 m/min	N
PA 66	suitable	200 m/min	N
PEEK	suitable	150 m/min	N

PF 31	suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		
Services			

Shank grinding Type HB

129100 HB