

## Garant

### GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e8 DC/ R1: 20/5,0mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 206257 20/5,0 |
| GTIN         | 4062406156480 |
| Item class   | 11X           |

#### Description

##### Version:

Cutting edge length to DIN 6527.

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

|   |                   |
|---|-------------------|
| Corner radius $R_1$                                     | 5 mm              |
| Flute length $L_c$                                      | 41 mm             |
| Overall length $L$                                      | 126 mm            |
| Balance quality with shank                              | G 2.5 with HA     |
| Helix angle   | 42 degrees        |
| Cutting edge $\varnothing D_c$                          | 20 mm             |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.18 mm           |
| Recess $\varnothing D_1$                                | 19.8 mm           |
| Overhang length $L_1$ incl. recess                      | 74 mm             |
| Shank $\varnothing D_s$                                 | 20 mm             |
| No. of teeth $Z$  | 3                 |
| Shank   | DIN 6535 HA to h6 |

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for copy milling in short-chipping aluminium | 0.2 mm                           |
| Series  | Master Alu                       |
| Coating   | DLC                              |
| Tool material   | Solid carbide                    |
| Standard  | Manufacturer's standard          |
| 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               | 0.03×D for copy 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 only under restricted conditions | 550 m/min | N        |
| Aluminium (short chipping) | suitable only under restricted conditions | 500 m/min | N        |
| Alu > 10% Si               | suitable only under restricted conditions | 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                                  |           |   |
| <b>Services</b>    |   |           |   |

Shank grinding Type HB

129100 HB