

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

Order data

Order number	206257 20/4,0
GTIN	4062406156473
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	4 mm
Flute length L_c	41 mm
Helix angle	42 degrees
Feed f_z for copy milling in short-chipping aluminium	0.2 mm
Recess $\varnothing D_1$	19.8 mm
Shank	DIN 6535 HA to h6
Overall length L	126 mm
Feed f_z for side milling in short-chipping aluminium	0.18 mm
Shank $\varnothing D_s$	20 mm
Overhang length L_1 incl. recess	74 mm
No. of teeth Z	3
Cutting edge $\varnothing D_c$	20 mm

Balance quality with shank	G 2.5 with HA
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		
Services			

Shank grinding Type HB

129100 HB