ʞ· Hoffmann Group

Garant

Solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 6mm

Order data

Order number	206263 6
GTIN	4062406279875
Item class	11X

Description

Version:
Special centre cutting edge geometry for traverse milling at very high feed rates.
Tolerance: Corner radius R_1 = ±0.01 mm.
Application:
For copy and traverse milling over the full range of hard machining **under HPC/HSC conditions.**
Using special milling strategies **very high rates of metal removal can be achieved.**
Note:
Tools can be reground.
With conically increasing recess to guarantee stability at long overhangs.

Technical description

Flute length L_c	3.5 mm
Shank Ø D_s	6 mm
Dimension $a_{p\,max}$ transverse	0.4 mm
No. of teeth Z	5
Overhang length L_1 incl. recess	28 mm
Cutting edge Ø D_c	6 mm
Overall length L	100 mm
Programming radius	1 mm
Feed f_z in steel < 900 N/mm^2	0.07 mm

Setting angle κ	12.5 degrees
maximum shank recess dia. D_6	5.9 mm
minimum shank recess dia. D_5	5.2 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal Ø	h9
Helix angle	15 degrees
Direction of infeed	horizontal and oblique
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Shank	DIN 6535 HA to h5
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End torus mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	170 m/min	P
Steel < 750 N/mm²	suitable	150 m/min	P
Steel < 900 N/mm²	suitable	135 m/min	P
Steel < 1100 N/mm²	suitable	130 m/min	P
Steel < 1400 N/mm²	suitable	125 m/min	P
INOX < 900 N/mm²	suitable	95 m/min	M
INOX > 900 N/mm²	suitable	90 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

dry	suitable only under restricted conditions
Air	suitable only under restricted conditions

Services

Shank grinding Type HB	129100 HB