

Garant

Solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 4mm



Order data

Order number	206263 4
GTIN	4062406279868
Item class	11X

Description

Version:

Special centre cutting edge geometry for traverse milling at very high feed rates.

Tolerance: Corner radius $R_1 = \pm 0.01$ 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

Setting angle κ	10.5 degrees
Flute length L_c	2.5 mm
No. of teeth Z	3
Dimension $a_{p \max}$ transverse	0.25 mm
Cutting edge $\varnothing D_c$	4 mm
Overhang length L_1 incl. recess	24 mm
Shank $\varnothing D_s$	6 mm
Feed f_z in steel < 900 N/mm ²	0.06 mm
Overall length L	85 mm

Programming radius	0.5 mm
maximum shank recess dia. D_6	3.95 mm
minimum shank recess dia. D_5	3.6 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal \varnothing	h9
Helix angle	15 degrees
Direction of infeed	horizontal and oblique
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	135 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable	125 m/min	P
INOX < 900 N/mm ²	suitable	95 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

dry	suitable only under restricted conditions
Air Services	suitable only under restricted conditions
Shank grinding Type HB	129100 HB