

Garant

GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e6 DC / R1: 5/1,0mm



Order data

Order number	206261 5/1,0
GTIN	4062406398415
Item class	11X

Description

Version:

Eccentric relief ground, additionally polish ground in the flutes for outstanding chip evacuation in long-chipping non-ferrous materials.

Very high feed rates when plunging vertically. Ramping capability up to 45°.

Tolerances:

· Corner radius

$R_1 = 0.5$ tolerance ± 0.02 mm.

$R_1 > 0.5 - 1.5$ tolerance ± 0.03 mm.

$R_1 > 1.5$ tolerance ± 0.05 mm.

Technical description

Corner radius R_1	1 mm
Flute length L_c	8 mm
Overhang length L_1 incl. recess	30 mm
Balance quality with shank	G 2.5 with HA
Overall length L	83 mm
Feed f_z for side milling in short-chipping aluminium	0.035 mm
Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	6 mm
Recess $\varnothing D_1$	4.7 mm

Cutting edge $\varnothing D_c$	5 mm
No. of teeth Z	3
Feed f_z for copy milling in short-chipping aluminium	0.04 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	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	340 m/min	N
Aluminium (short chipping)	Suitable	320 m/min	N
Alu > 10% Si	Suitable	290 m/min	N
PMMA acrylic	Suitable	150 m/min	N
PE-HD	Suitable	120 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	110 m/min	N

PF 31	Suitable	100 m/min	N
PVDF GF20	Suitable	130 m/min	N
POM GF25	Suitable	120 m/min	N
PA 66 GF30	Suitable	110 m/min	N
PEEK GF30	Suitable	100 m/min	N
PTFE CF25	Suitable	110 m/min	N
Honeycomb sandwich	suitable	220 m/min	N
Cu	Suitable	120 m/min	N
CuZn	Suitable	150 m/min	N
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	Suitable only under restricted conditions		
Air	Suitable		