

**Garant**
**GARANT Master Alu SlotMachine solid carbide torus cutter HPC / TPC, DLC, Ø e8 DC / R1: 12/1,0mm**

**Order data**

Order number	206258 12/1,0
GTIN	4062406398347
Item class	11X

**Description**
**Version:**

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

With a new knurled profile, optimised for higher feed rates. Tremendous bending strength due to the use of an innovative micrograin substrate.

**Technical description**

Feed $f_z$ for side milling in short-chipping aluminium	0.15 mm
Recess $\varnothing D_1$	11 mm
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
Shank $\varnothing D_s$	12 mm
Flute length $L_c$	49 mm
No. of teeth Z	3
Overall length L	100 mm
Overhang length $L_1$ incl. recess	60 mm
Corner radius $R_1$	1 mm
Cutting edge $\varnothing D_c$	12 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.13 mm

Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	WR
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	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	TPC
Machining strategy	HPC
Colour ring	yellow
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	450 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	380 m/min	N
PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 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