

**Garant**
**GARANT Master Alu SlotMachine solid carbide torus cutter HPC / TPC, DLC, Ø e8 DC / R1: 20/2,0mm**

**Order data**

Order number	206258 20/2,0
GTIN	4062406398378
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**

Recess Ø D <sub>1</sub>	19 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.25 mm
Shank	DIN 6535 HA to h6
Shank Ø D <sub>s</sub>	20 mm
Overhang length L <sub>1</sub> incl. recess	100 mm
Balance quality with shank	G 2.5 with HA
Flute length L <sub>c</sub>	82 mm
Overall length L	150 mm
Corner radius R <sub>1</sub>	2 mm
No. of teeth Z	4
Cutting edge Ø D <sub>c</sub>	20 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.2 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