

Garant
GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e6 DC / R1: 8/2,0mm

Order data

Order number	206261 8/2,0
GTIN	4062406398460
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

Shank Ø D_s	8 mm
No. of teeth Z	3
Recess Ø D_1	7.4 mm
Flute length L_c	13 mm
Overall length L	100 mm
Feed f_z for copy milling in short-chipping aluminium	0.05 mm
Overhang length L_1 incl. recess	62 mm
Balance quality with shank	G 2.5 with HA
Cutting edge Ø D_c	8 mm

Corner radius R_1	2 mm
Feed f_z for side milling in short-chipping aluminium	0.045 mm
Shank	DIN 6535 HA to h6
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		