

**Garant**
**GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e6 DC / R1: 8/1,0mm**

**Order data**

Order number	206261 8/1,0
GTIN	4062406398453
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  $\pm 0.02$  mm.**

**$R_1 > 0.5 - 1.5$  tolerance  $\pm 0.03$  mm.**

**$R_1 > 1.5$  tolerance  $\pm 0.05$  mm.**

**Technical description**

Flute length $L_c$	13 mm
Feed $f_z$ for copy milling in short-chipping aluminium	0.05 mm
Cutting edge $\varnothing D_c$	8 mm
Overall length $L$	100 mm
Shank	DIN 6535 HA to h6
Overhang length $L_1$ incl. recess	62 mm
Recess $\varnothing D_1$	7.4 mm
Shank $\varnothing D_s$	8 mm
Balance quality with shank	G 2.5 with HA

Feed $f_z$ for side milling in short-chipping aluminium	0.045 mm
Corner radius $R_1$	1 mm
No. of teeth Z	3
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		