

Garant

GARANT Master Alu SlotMachine solid carbide torus cutter HPC / TPC, DLC, Ø e8 DC / R1: 20/3,0mm



Order data

Order number	206258 20/3,0
GTIN	4062406398385
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 ₁	19 mm
Cutting edge Ø D _c	20 mm
Overall length L	150 mm
Balance quality with shank	G 2.5 with HA
No. of teeth Z	4
Shank	DIN 6535 HA to h6
Feed f _z for side milling in short-chipping aluminium	0.25 mm
Overhang length L ₁ incl. recess	100 mm
Corner radius R ₁	3 mm
Shank Ø D _s	20 mm
Flute length L _c	82 mm
Feed f _z 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