

**Garant**
**GARANT Master Alu solid carbide torus cutter HPC, DLC, Ø h6 DC / RS1:  
6/1,0mm**

**Order data**

Order number	206264 6/1,0
GTIN	4062406398590
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**

**RS<sub>1</sub> = 0.5 tolerance ±0.02.**

**RS<sub>1</sub> > 0.5 – 1.5 tolerance ±0.03.**

**RS<sub>1</sub> > 1.5 tolerance ±0.05.**

**Application:**

Particularly suitable for finishing work.

**Technical description**

Shank Ø D <sub>s</sub>	6 mm
Overall length L	65 mm
Recess Ø D <sub>1</sub>	5.7 mm
No. of teeth Z	4
Cutting edge Ø D <sub>c</sub>	6 mm
Corner radius R <sub>1</sub>	1 mm
Overhang length L <sub>1</sub> incl. recess	30 mm
Flute length L <sub>c</sub>	25 mm

Feed $f_z$ for side milling in short-chipping aluminium	0.045 mm
Shank	DIN 6535 HA to h6
Balance quality with shank	G 2.5 with HA
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	Full slot cutting depth $1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	500 m/min	N
Aluminium (short chipping)	Suitable	450 m/min	N
Alu > 10% Si	Suitable	400 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	140 m/min	N
PA 66	Suitable	180 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N

PVDF GF20	Suitable	160 m/min	N
POM GF25	Suitable	140 m/min	N
PA 66 GF30	Suitable	120 m/min	N
PEEK GF30	Suitable	140 m/min	N
PTFE CF25	Suitable	260 m/min	N
Honeycomb sandwich	suitable	260 m/min	N
Cu	Suitable	140 m/min	N
CuZn	Suitable	120 m/min	N
wet maximum	suitable		
wet minimum	Suitable only under restricted conditions		
dry	Suitable only under restricted conditions		
Air	Suitable		