

Garant
GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 12/1,0mm

Order data

| | |
|--------------|---------------|
| Order number | 206371 12/1,0 |
| GTIN | 4062406565329 |
| Item class | 11Z |

Description
Version:

Innovative substrate specially for machining **nickel-based alloys**. Newly developed coating.

Application:

For milling **nickel-based alloys with high red hardness**.

Technical description

| | |
|---|-------------------|
| Helix angle | 35 degrees |
| Overhang length L_1 incl. recess | 38 mm |
| Shank | DIN 6535 HB to h6 |
| Recess $\varnothing D_1$ | 11.6 mm |
| Cutting edge $\varnothing D_c$ | 12 mm |
| Shank $\varnothing D_s$ | 12 mm |
| Flute length L_c | 26 mm |
| Corner radius R_1 | 1 mm |
| Overall length L | 83 mm |
| No. of teeth Z | 4 |
| Feed f_z for side milling in Inconel® | 0.05 mm |
| Series | Master Ni-based |
| Coating | TiAlN |

| | |
|---|----------------------------------|
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Tolerance nominal \varnothing | f8 |
| 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 | 0.3×D for side milling |
| Cutting width a_e for milling operation | 0.05×D for copy milling |
| Through-coolant | no |
| Machining strategy | HPC |
| Shank tolerance | h6 |
| Colour ring | pink |
| Type of product | Torus cutter |

User data

| | Suitability | V_c | ISO code |
|-------------|-------------|----------|----------|
| Inconel | suitable | 40 m/min | S |
| wet maximum | suitable | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|