

**Garant**
**GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 10/1,0mm**

**Order data**

Order number	206371 10/1,0
GTIN	4062406565299
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**

Overhang length $L_1$ incl. recess	32 mm
Shank $\varnothing D_s$	10 mm
Overall length L	72 mm
Shank	DIN 6535 HB to h6
No. of teeth Z	4
Cutting edge $\varnothing D_c$	10 mm
Corner radius $R_1$	1 mm
Recess $\varnothing D_1$	9.7 mm
Helix angle	35 degrees
Flute length $L_c$	22 mm
Feed $f_z$ for side milling in Inconel®	0.042 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
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