

Garant
GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 6/1,0mm

Order data

Order number	206371 6/1,0
GTIN	4062406565268
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

Corner radius R_1	1 mm
Helix angle	35 degrees
Overhang length L_1 incl. recess	20 mm
Flute length L_c	13 mm
Cutting edge $\varnothing D_c$	6 mm
No. of teeth Z	4
Shank $\varnothing D_s$	6 mm
Recess $\varnothing D_1$	5.8 mm
Shank	DIN 6535 HB to h6
Overall length L	57 mm
Feed f_z for side milling in Inconel®	0.026 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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