

**Garant**
**GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 5/1,0mm**

**Order data**

Order number	206371 5/1,0
GTIN	4062406565244
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
Overall length $L$	57 mm
Flute length $L_c$	13 mm
Cutting edge $\varnothing D_c$	5 mm
No. of teeth $Z$	4
Helix angle	35 degrees
Recess $\varnothing D_1$	4.8 mm
Shank $\varnothing D_s$	6 mm
Shank	DIN 6535 HB to h6
Overhang length $L_1$ incl. recess	18 mm
Feed $f_z$ for side milling in Inconel®	0.022 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
------------------------	-----------