

**Garant**
**GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø f8 DC / R1: 8/1,0mm**

**Order data**

Order number	206373 8/1,0
GTIN	4062406565411
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**.

For finishing operations.

**Technical description**

Shank Ø D <sub>s</sub>	8 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	6
Helix angle	50 degrees
Corner radius R <sub>1</sub>	1 mm
Recess Ø D <sub>1</sub>	7.8 mm
Overall length L	71 mm
Overhang length L <sub>1</sub> incl. recess	33 mm
Flute length L <sub>c</sub>	25 mm
Cutting edge Ø D <sub>c</sub>	8 mm
Feed f <sub>z</sub> for side milling in Inconel®	0.035 mm
Series	Master Ni-based

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
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 $1 \times D$
Cutting width $a_e$ for milling operation	$0.05 \times D$ 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	50 m/min	S
wet maximum	suitable		