

Garant
GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø f8 DC / R1: 12/1,0mm

Order data

Order number	206373 12/1,0
GTIN	4062406565459
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

Overall length L	94 mm
Flute length L _c	37 mm
Overhang length L ₁ incl. recess	47 mm
Shank	DIN 6535 HA to h6
Cutting edge Ø D _c	12 mm
Shank Ø D _s	12 mm
Corner radius R ₁	1 mm
Helix angle	50 degrees
Recess Ø D ₁	11.8 mm
No. of teeth Z	6
Feed f _z for side milling in Inconel®	0.05 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		