

Garant
Solid carbide torus cutter HPC DIN 6535 HA, TiAlN, Ø DC / R1: 4/0,4mm

Order data

Order number	206351 4/0,4
GTIN	4045197542168
Item class	11X

Description
Version:

Dimensions to DIN 6527 and 38° flutes.

Tolerance: Corner radius $R_1 = \pm 0.005 \text{ mm}$.

Note:

NEW GENERATION AVAILABLE!

Recommended successor product is No. 206345

Technical description

Cutting edge Ø D_c	4 mm
Overhang length L_1 incl. recess	16 mm
No. of teeth Z	4
Feed f_z for copy milling in stainless steel > 900 N/mm ²	0.02 mm
Recess Ø D_1	3.6 mm
Corner radius R_1	0.4 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.016 mm
Shank Ø D_s	6 mm
Flute length L_c	12 mm
Overall length L	57 mm
Shank	DIN 6535 HA to h6
Helix angle	38 degrees

Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
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	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	blue
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	230 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	50 m/min	S

Uni	suitable only under restricted conditions
wet maximum	suitable
wet minimum	Suitable
dry	Suitable only under restricted conditions
Air	suitable only under restricted conditions
Services	
Shank grinding Type HB	129100 HB