

Garant
Solid carbide torus cutter HPC DIN 6535 HA, TiAlN, Ø DC / R1: 4/1,0mm

Order data

| | |
|--------------|---------------|
| Order number | 206351 4/1,0 |
| GTIN | 4045197542182 |
| 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

| | |
|---|-------------------|
| Feed f_z for copy milling in stainless steel $> 900 \text{ N/mm}^2$ | 0.016 mm |
| Cutting edge Ø D_c | 4 mm |
| Overhang length L_1 incl. recess | 16 mm |
| Feed f_z for side milling in INOX $> 900 \text{ N/mm}^2$ | 0.013 mm |
| No. of teeth Z | 4 |
| Corner radius R_1 | 1 mm |
| Recess Ø D_1 | 3.6 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 |

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|---|----------------------------------|
| 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 |