

Garant
GARANT Master INOX solid carbide torus cutter HPC DIN 6535 HA, TiAlN, Ø DC / R1: 8/1,0mm

Order data

| | |
|--------------|---------------|
| Order number | 206345 8/1,0 |
| GTIN | 4045197852021 |
| Item class | 11X |

Description
Version:

Dimensions similar to DIN 6527.

HPC milling cutter with **newly developed high-performance coating**.

For **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

Advantage:

Greater oxidation resistance and high-temperature hardness.

Technical description

| | |
|--|-------------------|
| Shank Ø D _s | 8 mm |
| Feed f _z for side milling in INOX > 900 N/mm ² | 0.043 mm |
| Recess Ø D ₁ | 7.5 mm |
| Overall length L | 63 mm |
| Shank | DIN 6535 HA to h6 |
| Overhang length L ₁ incl. recess | 27 mm |
| Flute length L _c | 16 mm |
| Corner radius R ₁ | 1 mm |
| No. of teeth Z | 4 |
| Cutting edge Ø D _c | 8 mm |

| | |
|---|----------------------------------|
| Helix angle | 40 degrees |
| Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$ | 0.035 mm |
| Series | Master INOX |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | h10 |
| 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 | $0.3 \times D$ for side milling |
| Cutting width a_e for milling operation | $0.05 \times D$ for side 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 $< 500 \text{ N/mm}^2$ | suitable | 250 m/min | P |
| Steel $< 750 \text{ N/mm}^2$ | suitable | 230 m/min | P |
| Steel $< 900 \text{ N/mm}^2$ | suitable | 200 m/min | P |
| Steel $< 1100 \text{ N/mm}^2$ | suitable | 180 m/min | P |
| Steel $< 1400 \text{ N/mm}^2$ | suitable | 170 m/min | P |
| TOOLOX 33 | suitable | 115 m/min | H |
| TOOLOX 44 | suitable | 80 m/min | H |
| INOX $< 900 \text{ N/mm}^2$ | suitable | 110 m/min | M |

| | | | |
|------------------------------|---|----------|---|
| INOX > 900 N/mm ² | suitable | 90 m/min | M |
| Uni | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| dry | Suitable only under restricted conditions | | |
| Air | suitable | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
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