

## Garant

### GARANT Master INOX solid carbide torus cutter HPC DIN 6535 HA, TiAlN, Ø DC / R1: 8/1,5mm



#### Order data

Order number	206345 8/1,5
GTIN	4045197852038
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

Recess Ø D <sub>1</sub>	7.5 mm
Cutting edge Ø D <sub>c</sub>	8 mm
Shank Ø D <sub>s</sub>	8 mm
Shank	DIN 6535 HA to h6
Corner radius R <sub>1</sub>	1.5 mm
Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>	0.043 mm
Overall length L	63 mm
No. of teeth Z	4
Overhang length L <sub>1</sub> incl. recess	27 mm
Flute length L <sub>c</sub>	16 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 <sup>2</sup>	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		
<b>Services</b>			
Shank grinding Type HB		129100 HB	