

Garant
GARANT Master INOX solid carbide torus cutter HPC DIN 6535 HB, TiAlN, Ø DC / R1: 20/1,0mm

Order data

Order number	206347 20/1,0
GTIN	4045197852656
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 ₁	19 mm
Overall length L	104 mm
Shank	DIN 6535 HB to h6
Cutting edge Ø D _c	20 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.111 mm
Overhang length L ₁ incl. recess	54 mm
Corner radius R ₁	1 mm
Shank Ø D _s	20 mm
Flute length L _c	38 mm
No. of teeth Z	4

Helix angle	40 degrees
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.09 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		