

Garant
Solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 5mm

Order data

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|--------------|---------------|
| Order number | 206266 5 |
| GTIN | 4045197860637 |
| Item class | 11X |

Description
Version:

Special centre cutting edge geometry for traverse milling at very high feed rates.

Tolerance: Corner radius $R_1 = \pm 0.01 \text{ mm}$.

Application:

For copy and traverse milling over the full range of hard machining **under HPC/HSC conditions**.

Using special milling strategies **very high rates of metal removal can be achieved**.

Note:

Successor product to No. 206272.

Tools can be reground.

Technical description

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| Overall length L | 65 mm |
| Cutting edge Ø D_c | 5 mm |
| Overhang length L_1 incl. recess | 18 mm |
| Programming radius | 0.5 mm |
| Flute length L_c | 3.5 mm |
| Shank Ø D_s | 6 mm |
| Recess Ø D_1 | 4.6 mm |
| Dimension $a_{p \text{ max}}$ transverse | 0.35 mm |
| Feed f_z in steel < 900 N/mm ² | 0.099 mm |

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|---|--------------------------------------|
| No. of teeth Z | 4 |
| Setting angle κ | 9.5 degrees |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | h9 |
| Helix angle | 15 degrees |
| Direction of infeed | horizontal and oblique |
| Cutting width a_e for milling operation | Full slot cutting depth $1 \times D$ |
| Shank | DIN 6535 HA to h5 |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | End torus mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 155 m/min | P |
| Steel < 750 N/mm ² | suitable | 150 m/min | P |
| Steel < 900 N/mm ² | suitable | 145 m/min | P |
| Steel < 1100 N/mm ² | suitable | 140 m/min | P |
| Steel < 1400 N/mm ² | suitable | 130 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 90 m/min | M |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

| | |
|------------------------|---|
| dry | suitable only under restricted conditions |
| Air Services | suitable only under restricted conditions |
| Shank grinding Type HB | 129100 HB |