

Garant
Solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 4mm

Order data

Order number	206267 4
GTIN	4045197860705
Item class	11X

Description
Version:

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

Tolerance: Corner radius $R_1 = \pm 0.01$ 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. 206274.

Tools can be reground.

Technical description

Shank Ø D_s	6 mm
No. of teeth Z	2
Flute length L_c	2.5 mm
Feed f_z in steel < 900 N/mm ²	0.06 mm
Recess Ø D_1	3.6 mm
Dimension $a_{p\ max}$ transverse	0.25 mm
Overall length L	85 mm
Overhang length L_1 incl. recess	24 mm
Cutting edge Ø D_c	4 mm
Programming radius	0.5 mm

Setting angle κ	10.5 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	150 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	125 m/min	P
Steel < 1400 N/mm ²	suitable	115 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	80 m/min	M
Uni	suitable		
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