

Garant

GARANT Master Titan solid carbide torus cutter HPC, TiAlN, Ø DC / R1: 20/1,0mm



Order data

Order number	206364 20/1,0
GTIN	4045197991980
Item class	11Z

Description

Version:

Tolerance: Corner radius $R_1 = \pm 0.005 \text{ mm}$.

Application:

For milling **titanium and titanium alloys**; with very smooth cutting action for optimum tool life and top metal removal rate.

Technical description

Overhang length L_1 incl. recess	54 mm
Feed f_z for copy milling in titanium $> 850 \text{ N/mm}^2$	0.1 mm
No. of teeth Z	4
Flute length L_c	41 mm
Feed f_z for side milling in titanium $> 850 \text{ N/mm}^2$	0.08 mm
Shank $\varnothing D_s$	20 mm
Correction factor for v_c	1.5
Recess $\varnothing D_1$	19.5 mm
Cutting edge $\varnothing D_c$	20 mm
Overall length L	104 mm
Helix angle	40 degrees
Shank	DIN 6535 HA to h6

Corner radius R_1	1 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Tolerance nominal \varnothing	e8
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	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	pink
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Ti > 850 N/mm ²	suitable	60 m/min	S
wet maximum	suitable		

Services

Shank grinding Type HB	129100 HB
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