

**Garant**
**GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e8 DC/  
R1: 10/1,0mm**

**Order data**

Order number	206257 10/1,0
GTIN	4062406156404
Item class	11X

**Description**
**Version:**

Cutting edge length to DIN 6527.

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

**Application:**

Especially for **high speed machining** in **mould and tool making** for **copy milling**.

No. of teeth Z: 3

Helix angle: 42 °

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length  $L_c$ : 22 mm

Corner radius  $R_1$ : 1 mm

Overhang length  $L_1$  incl. recess: 38 mm

Recess Ø  $D_1$ : 9.8 mm

Overall length L: 80 mm

**Technical description**

Feed $f_z$ for copy milling in short-chipping aluminium	0.11 mm
No. of teeth Z	3
Cutting edge Ø $D_c$	10 mm
Overhang length $L_1$ incl. recess	38 mm
Corner radius $R_1$	1 mm

Overall length L	80 mm
Shank	DIN 6535 HA to h6
Recess $\varnothing D_1$	9.8 mm
Shank $\varnothing D_s$	10 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.08 mm
Flute length $L_c$	22 mm
Balance quality with shank	G 2.5 with HA
Helix angle	42°
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
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	0.03×D for copy milling
Cutting width $a_e$ for milling operation	0.5×D for side milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	550 m/min	N

Aluminium (short chipping)	suitable only under restricted conditions	500 m/min	N
Alu > 10% Si	suitable only under restricted conditions	450 m/min	N
PMMA acrylic	suitable	200 m/min	N
PE-HD	suitable	160 m/min	N
PA 66	suitable	200 m/min	N
PEEK	suitable	150 m/min	N
PF 31	suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N
POM GF25	suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air Services	suitable		

Shank grinding Type HB

129100 HB