

**Garant**
**GARANT Master Alu SlotMachine solid carbide torus cutter HPC / TPC, DLC, Ø e8 DC / R1: 6/1,0mm**

**Order data**

Order number	206258 6/1,0
GTIN	4062406396886
Item class	11X

**Description**
**Version:**

Eccentric relief ground, additionally polish ground in the flutes for outstanding chip evacuation in long-chipping non-ferrous materials.

With a new knurled profile, optimised for higher feed rates. Tremendous bending strength due to the use of an innovative micrograin substrate.

No. of teeth Z: 3

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length  $L_c$ : 25 mm

Corner radius  $R_1$ : 1 mm

Overhang length  $L_1$  incl. recess: 30 mm

Recess Ø  $D_1$ : 5.5 mm

Overall length L: 65 mm

**Technical description**

No. of teeth Z	3
Cutting edge Ø $D_c$	6 mm
Corner radius $R_1$	1 mm
Overall length L	65 mm
Overhang length $L_1$ incl. recess	30 mm
Shank	DIN 6535 HA to h6

Balance quality with shank	G 2.5 with HA
Recess $\varnothing D_1$	5.5 mm
Shank $\varnothing D_s$	6 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.08 mm
Flute length $L_c$	25 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.07 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	WR
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	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	TPC
Machining strategy	HPC
Colour ring	yellow
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	450 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	380 m/min	N

PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 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	Suitable		