

Garant
**GARANT Master Steel solid carbide torus cutter HPC, TiAlN, Ø DC / R1:
4/0,4mm**

Order data

Order number	206354 4/0,4
GTIN	4045197777997
Item class	11X

Description
Version:

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

Advantage:

HPC milling cutters with various corner radii for all radial transitions.
Optimised flute form, eccentric relief ground, wide chip space.

No. of teeth Z: 4

Helix angle: 38°

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length L_c : 11 mm

Corner radius R_1 : 0.4 mm

Overall length L: 57 mm

Shank $\varnothing D_s$: 6 mm

Feed f_z for slot milling in steel < 900 N/mm²: 0.02 mm

Technical description

Shank $\varnothing D_s$	6 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.025 mm
Overall length L	57 mm
Corner radius R_1	0.4 mm
Flute length L_c	11 mm
No. of teeth Z	4

Cutting edge $\varnothing D_c$	4 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.02 mm
Shank	DIN 6535 HB to h6
Helix angle	38 °
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Tolerance nominal \varnothing	f8
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×D
Cutting width a_e for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	260 m/min	P
Steel < 750 N/mm ²	suitable	240 m/min	P
Steel < 900 N/mm ²	suitable	190 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M

INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		