

Garant
GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 4/0,5mm

Order data

Order number	206371 4/0,5
GTIN	4062406565237
Item class	11Z

Description
Version:

Innovative substrate specially for machining **nickel-based alloys**. Newly developed coating.

Application:

For milling **nickel-based alloys with high red hardness**.

No. of teeth Z: 4

Helix angle: 35 °

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length L_c : 11 mm

Corner radius R_1 : 0.5 mm

Overhang length L_1 incl. recess: 16 mm

Recess Ø D_1 : 3.8 mm

Overall length L: 57 mm

Technical description

Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	16 mm
Recess Ø D_1	3.8 mm
Helix angle	35 °
Flute length L_c	11 mm
Shank Ø D_s	6 mm
Overall length L	57 mm

Cutting edge $\varnothing D_c$	4 mm
Corner radius R_1	0.5 mm
No. of teeth Z	4
Feed f_z for side milling in Inconel®	0.018 mm
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	0.3×D for side milling
Cutting width a_e for milling operation	0.05×D for copy 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
Inconel	suitable	40 m/min	S
wet maximum	suitable		

Services

Shank grinding Type HB	129100 HB
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