

## Garant

### GARANT Master INOX solid carbide torus cutter HPC DIN 6535 HB, TiAlN, Ø DC / R1: 3/0,3mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 206347 3/0,3  |
| GTIN         | 4045197852304 |
| Item class   | 11X           |

#### Description

##### Version:

Dimensions similar to DIN 6527.

HPC milling cutter with **newly developed high-performance coating**.

For **outstanding tool life** and **optimum metal removal rate** in a very wide range of stainless steels.

Can be used at **high cutting speeds**, particularly suitable even for TOOLOX®.

##### Advantage:

**Greater oxidation resistance and high-temperature hardness.**

No. of teeth Z: 4

Helix angle: 40°

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 8 mm

Corner radius  $R_1$ : 0.3 mm

Overhang length  $L_1$  incl. recess: 14 mm

Recess Ø  $D_1$ : 2.9 mm

Overall length L: 57 mm

#### Technical description

|                     |        |
|---------------------|--------|
| Corner radius $R_1$ | 0.3 mm |
| Shank Ø $D_s$       | 6 mm   |
| No. of teeth Z      | 4      |
| Flute length $L_c$  | 8 mm   |

|  |                                  |
|--|----------------------------------|
| Recess $\varnothing D_1$   | 2.9 mm                           |
| Shank  | DIN 6535 HB to h6                |
| Cutting edge $\varnothing D_c$   | 3 mm                             |
| Overhang length $L_1$ incl. recess                                     | 14 mm                            |
| Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>            | 0.018 mm                         |
| Overall length L   | 57 mm                            |
| Helix angle  | 40 °                             |
| Feed $f_z$ for slot milling in stainless steel > 900 N/mm <sup>2</sup> | 0.015 mm                         |
| Series   | Master Inox                      |
| Coating  | TiAlN                            |
| Tool material  | Solid carbide                    |
| Standard   | Manufacturer's standard          |
| Type   | N                                |
| Tolerance nominal $\varnothing$  | h10                              |
| 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 side milling          |
| Through-coolant  | no                               |
| Machining strategy   | HPC                              |
| Shank tolerance  | h6                               |
| Colour ring  | blue                             |
| Type of product  | Torus cutter                     |

## User data

|                               | Suitability | $V_c$     | ISO code |
|-------------------------------|-------------|-----------|----------|
| Steel < 500 N/mm <sup>2</sup> | suitable    | 250 m/min | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable    | 230 m/min | P        |

|                                |   |           |   |
|--------------------------------|---|-----------|---|
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 200 m/min | P |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 180 m/min | P |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 170 m/min | P |
| TOOLOX 33                      | suitable                                  | 115 m/min | H |
| TOOLOX 44                      | suitable                                  | 80 m/min  | H |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 110 m/min | M |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 90 m/min  | M |
| Uni                            | suitable only under restricted conditions |           |   |
| wet maximum                    | suitable                                  |           |   |
| wet minimum                    | suitable                                  |           |   |
| dry                            | Suitable only under restricted conditions |           |   |
| Air                            | suitable                                  |           |   |