

Garant

GARANT Master INOX solid carbide torus cutter HPC DIN 6535 HA, TiAlN, Ø DC / R1: 12/4,0mm



Order data

Order number	206345 12/4,0
GTIN	4045197852199
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.

Technical description

No. of teeth Z	4
Flute length L _c	26 mm
Shank	DIN 6535 HA to h6
Shank Ø D _s	12 mm
Overall length L	83 mm
Cutting edge Ø D _c	12 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.062 mm
Overhang length L ₁ incl. recess	38 mm
Corner radius R ₁	4 mm
Recess Ø D ₁	11.5 mm

Helix angle	40 degrees
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.05 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	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.05 \times D$ 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 $< 500 \text{ N/mm}^2$	suitable	250 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	230 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	170 m/min	P
TOOLOX 33	suitable	115 m/min	H
TOOLOX 44	suitable	80 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	110 m/min	M

INOX > 900 N/mm ²	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		

Services

Shank grinding Type HB	129100 HB
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