

Garant
GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 20/1,0mm

Order data

Order number	206371 20/1,0
GTIN	4062406565367
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**.

Technical description

Cutting edge Ø D _c	20 mm
Shank	DIN 6535 HB to h6
Helix angle	35 degrees
Corner radius R ₁	1 mm
Flute length L _c	41 mm
Overall length L	104 mm
No. of teeth Z	5
Recess Ø D ₁	19.5 mm
Shank Ø D _s	20 mm
Overhang length L ₁ incl. recess	54 mm
Feed f _z for side milling in Inconel®	0.08 mm
Series	Master Ni-based
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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