

Garant
**GARANT Master Steel solid carbide torus cutter HPC, TiAlN, Ø DC / R1:
8/1,0mm**

Order data

Order number	206359 8/1,0
GTIN	4045197943408
Item class	11X

Description
Version:

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

Advantage:

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

Technical description

Shank	DIN 6535 HB to h6
Helix angle	38 degrees
Corner radius R_1	1 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.05 mm
Shank $\varnothing D_s$	8 mm
Overall length L	68 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.06 mm
Recess $\varnothing D_1$	7.7 mm
Overhang length L_1 incl. recess	30 mm
Cutting edge $\varnothing D_c$	8 mm
Flute length L_c	21 mm
No. of teeth Z	4

Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
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 $1 \times D$
Cutting width a_e for milling operation	$0.3 \times D$ 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