

**Garant**
**GARANT Master Ni-Based torus cutter HPC, TiAlN, Ø DC / R1: 12/1,0 mm**

**Order data**

Order number	206371 12/1,0
GTIN	4062406565329
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 degrees

Shank: DIN 6535 HB to h6

No. of teeth Z: 4

Flute length  $L_c$ : 26 mm

Corner radius  $R_1$ : 1 mm

Overhang length  $L_1$  incl. recess: 38 mm

Recess Ø  $D_1$ : 11.6 mm

Overall length L: 83 mm

**Technical description**

Helix angle	35 degrees
Overhang length $L_1$ incl. recess	38 mm
Shank	DIN 6535 HB to h6
Recess Ø $D_1$	11.6 mm
Cutting edge Ø $D_c$	12 mm
Shank Ø $D_s$	12 mm
Flute length $L_c$	26 mm

Corner radius $R_1$	1 mm
Overall length L	83 mm
No. of teeth Z	4
Feed $f_z$ for side milling in Inconel®	0.05 mm
Series	GARANT Master Titan
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	$0.3 \times D$ for side milling
Cutting width $a_e$ for milling operation	$0.05 \times D$ for copy milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	pink
Type of product	End mill

## Services

Shank grinding Type HB	129100 HB
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