

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

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**.

No. of teeth Z: 5

Helix angle: 35 degrees

Shank: DIN 6535 HB to h6

No. of teeth Z: 5

Flute length L_c : 41 mm

Corner radius R_1 : 1 mm

Overhang length L_1 incl. recess: 54 mm

Recess Ø D_1 : 19.5 mm

Overall length L: 104 mm

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 $\varnothing D_1$	19.5 mm
Shank $\varnothing D_s$	20 mm
Overhang length L_1 incl. recess	54 mm
Feed f_z for side milling in Inconel®	0.08 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×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	End mill

Services

Shank grinding Type HB	129100 HB
------------------------	-----------