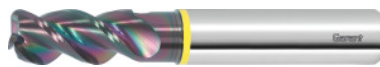


Garant
Solid carbide torus cutter, DLC, Ø h6 DC / R1: 4/1,0mm

Order data

Order number	206230 4/1,0
GTIN	4062406127664
Item class	11X

Description
Version:

With the latest generation of **DLC coating sp²**.

Eccentric relief ground, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium components.

Tolerances:

- **Corner radius**

R₁ = 0.5 tolerance ±0.02.

R₁ > 0.5 – 1.5 tolerance ±0.03.

R₁ > 1.5 tolerance ±0.05.

Note:

NEW GENERATION AVAILABLE! Recommended successor product is No. 206255.

Technical description

Feed f_z for copy milling in short-chipping aluminium	0.02 mm
Cutting edge Ø D_c	4 mm
Shank Ø D_s	6 mm
No. of teeth Z	3
Helix angle	45 degrees
Corner radius R_1	1 mm
Overall length L	57 mm
Recess Ø D_1	3.7 mm
Feed f_z for side milling in short-chipping aluminium	0.02 mm

Balance quality with shank	G 2.5 with HA
Shank	DIN 6535 HA to h6
Flute length L_c	11 mm
Overhang length L_1 incl. recess	17 mm
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Tolerance nominal \varnothing	h6
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	0.05×D for copy milling
Through-coolant	no
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Aluminium	suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	suitable	200 m/min	N
PE-HD	suitable	160 m/min	N
PA 66	suitable	200 m/min	N
PEEK	suitable	150 m/min	N
PF 31	suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N

POM GF25	suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	Suitable		
Services			

Shank grinding Type HB

129100 HB