

**Garant**
**Solid carbide torus cutter, DLC, Ø h6 DC / R1: 20/5,0mm**

**Order data**

Order number	206230 20/5,0
GTIN	4062406127701
Item class	11X

**Description**
**Version:**

With the latest generation of **DLC coating sp<sup>2</sup>**.

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

Tolerances:

- **Corner radius**

**R<sub>1</sub> = 0.5 tolerance ±0.02.**

**R<sub>1</sub> > 0.5 – 1.5 tolerance ±0.03.**

**R<sub>1</sub> > 1.5 tolerance ±0.05.**

**Note:**

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

**Technical description**

No. of teeth Z	3
Flute length L <sub>c</sub>	41 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.12 mm
Corner radius R <sub>1</sub>	5 mm
Feed f <sub>z</sub> for copy milling in short-chipping aluminium	0.13 mm
Recess Ø D <sub>1</sub>	19 mm
Shank Ø D <sub>s</sub>	20 mm
Balance quality with shank	G 2.5 with HA
Cutting edge Ø D <sub>c</sub>	20 mm

Helix angle	45 degrees
Overhang length $L_1$ incl. recess	52 mm
Overall length L	104 mm
Shank	DIN 6535 HA to h6
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