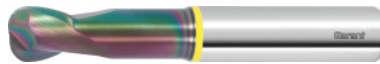


Garant
Solid carbide torus cutter, DLC, Ø e8 DC / R1: 12/1,5mm

Order data

Order number	206065 12/1,5
GTIN	4045197766328
Item class	11X

Description
Version:

Tolerance: $R_1 = \pm 0.01 \text{ mm}$.

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

With **double relief ground side clearance angle and corner radius**.

High strength due to **strengthened core**.

Technical description

Corner radius R_1	1.5 mm
Shank $\varnothing D_s$	12 mm
Overall length L	83 mm
Flute length L_c	12 mm
Cutting edge $\varnothing D_c$	12 mm
Feed f_z for copy milling in short-chipping aluminium	0.079 mm
Feed f_z for side milling in short-chipping aluminium	0.07 mm
Overhang length L_1 incl. recess	38 mm
Recess $\varnothing D_1$	11 mm
No. of teeth Z	2
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Coating	DLC

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Tolerance nominal \varnothing	e8
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.5×D for side milling
Through-coolant	no
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	330 m/min	N
Aluminium (short chipping)	suitable	300 m/min	N
Alu > 10% Si	suitable	230 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	100 m/min	N
CuZn	Suitable	120 m/min	N
wet maximum	suitable		
wet minimum	Suitable		
dry	suitable only under restricted conditions		
Air Services	Suitable		
Shank grinding Type HB		129100 HB	