

Garant

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



Order data

Order number	206075 12/1,5
GTIN	4045197766595
Item class	11X

Description

Version:

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

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

High stability due to **strengthened core**.

Tolerance: **R₁ = ±0.01 mm**.

Technical description

Shank Ø D _s	12 mm
Flute length L _c	12 mm
Corner radius R ₁	1.5 mm
Cutting edge Ø D _c	12 mm
Overall length L	160 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	115 mm
Recess Ø 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	0.1×D for side milling
Through-coolant	no
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Aluminium	Suitable	180 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	130 m/min	N
PE-HD	Suitable	80 m/min	N
PA 66	Suitable	100 m/min	N
PEEK	Suitable	80 m/min	N
PF 31	Suitable	70 m/min	N
PVDF GF20	Suitable	90 m/min	N
POM GF25	Suitable	80 m/min	N
PA 66 GF30	Suitable	70 m/min	N
PEEK GF30	Suitable	70 m/min	N
PTFE CF25	Suitable	80 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