

**Garant**
**Solid carbide torus cutter, uncoated,  $\varnothing$  e8 DC / R1: 12/4,0mm**

**Order data**

Order number	206040 12/4,0
GTIN	4045197122858
Item class	11X

**Description**
**Version:**

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

**High strength** due to **strengthened core.**

Tolerance:  $R_1 = \pm 0.01$  mm.

**Technical description**

Feed $f_z$ for copy milling in short-chipping aluminium	0.079 mm
Overhang length $L_1$ incl. recess	38 mm
Corner radius $R_1$	4 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.07 mm
Recess $\varnothing D_1$	11 mm
No. of teeth $Z$	2
Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Flute length $L_c$	12 mm
Overall length $L$	83 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Coating	uncoated

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	0.5×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	180 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable	105 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N
Cu	Suitable	80 m/min	N
CuZn	Suitable	100 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

suitable only under  
restricted conditions

**Services**

Shank grinding Type HB

129100 HB