

Garant
Solid carbide torus cutter HPC, ZOx, Ø f8 DC / R1: 20/4,0mm

Order data

Order number	206260 20/4,0
GTIN	4045197300973
Item class	11X

Description
Version:

With strong core, **special chip breaker recesses** and **large polished flutes**.
New generation of high performance end mills in the HPC machining range.

Application:

Especially for **high speed machining** in **mould and tool making** for **copy milling**.

Note:

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

Technical description

Corner radius R_1	4 mm
No. of teeth Z	3
Feed f_z for copy milling in short-chipping aluminium	0.1 mm
Recess $\varnothing D_1$	19 mm
Cutting edge $\varnothing D_c$	20 mm
Overhang length L_1 incl. recess	52 mm
Feed f_z for side milling in short-chipping aluminium	0.1 mm
Shank $\varnothing D_s$	20 mm
Flute length L_c	41 mm
Overall length L	104 mm
Balance quality with shank	G 2.5 with HA

Shank	DIN 6535 HA to h6
Helix angle	45 degrees
Coating	ZOX
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Tolerance nominal \varnothing	f8
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	0.03×D for copy milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Aluminium	suitable only under restricted conditions	500 m/min	N
Aluminium (short chipping)	suitable	480 m/min	N
Alu > 10% Si	suitable	240 m/min	N
Cu	Suitable	200 m/min	N
CuZn	suitable	240 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