

Garant

Solid carbide torus cutter HPC, ZOx, Ø f8 DC / R1: 8/0,5mm



Order data

| | |
|--------------|---------------|
| Order number | 206260 8/0,5 |
| GTIN | 4045197300898 |
| 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

| | |
|--|---------------|
| No. of teeth Z | 3 |
| Corner radius R ₁ | 0.5 mm |
| Feed f _z for side milling in short-chipping aluminium | 0.055 mm |
| Overhang length L ₁ incl. recess | 25 mm |
| Cutting edge Ø D _c | 8 mm |
| Feed f _z for copy milling in short-chipping aluminium | 0.055 mm |
| Recess Ø D ₁ | 7.4 mm |
| Shank Ø D _s | 8 mm |
| Flute length L _c | 21 mm |
| Overall length L | 63 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 |