

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

Order data

Order number	206280 12/1,5
GTIN	4045197124104
Item class	11X

Description
Version:

With **double relief ground side clearance angle**.

Tolerance: Corner radius $R_1 = \pm 0.005 \text{ mm}$.

Application:

Especially for **high speed machining** in **mould and tool making** for **copy milling**. Excellent results when **milling dry**.

Note:

NEW GENERATION AVAILABLE!

Recommended successor product is No. 206333.

Technical description

Recess $\varnothing D_1$	11 mm
Overhang length L_1 incl. recess	38 mm
Corner radius R_1	1.5 mm
Feed f_z for side milling in steel $< 1100 \text{ N/mm}^2$	0.04 mm
Feed f_z for copy milling in steel $< 1100 \text{ N/mm}^2$	0.045 mm
No. of teeth Z	4
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	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
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	0.2×D for side milling
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable	155 m/min	P
Steel < 900 N/mm ²	suitable	110 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
GG(G)	suitable	100 m/min	K
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		

Air
Services

Suitable

Shank grinding Type HB

129100 HB