

Garant

Solid carbide torus cutter, TiAlN, Ø e8 DC / R1: 4/1,0mm



Order data

| | |
|--------------|---------------|
| Order number | 206300 4/1,0 |
| GTIN | 4045197124265 |
| Item class | 11X |

Description

Version:

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

Tolerance: Corner radius $R_1 = \pm 0.005$ 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. 206335.

Technical description

| | |
|---|----------|
| Corner radius R_1 | 1 mm |
| No. of teeth Z | 4 |
| Feed f_z for copy milling in steel < 1100 N/mm ² | 0.014 mm |
| Feed f_z for side milling in steel < 1100 N/mm ² | 0.013 mm |
| Overhang length L_1 incl. recess | 36 mm |
| Recess Ø D_1 | 3.7 mm |
| Cutting edge Ø D_c | 4 mm |
| Shank Ø D_s | 4 mm |
| Flute length L_c | 5 mm |
| Overall length L | 75 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 | 140 m/min | P |
| Steel < 900 N/mm ² | suitable | 100 m/min | P |
| Steel < 1100 N/mm ² | suitable | 70 m/min | P |
| Steel < 1400 N/mm ² | suitable | 60 m/min | P |
| Steel < 55 HRC | suitable only under restricted conditions | 35 m/min | H |
| INOX < 900 N/mm ² | suitable | 80 m/min | M |
| GG(G) | suitable | 90 m/min | K |
| wet maximum | Suitable | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |

Air

Suitable