



## Solid carbide torus cutter HPC DIN 6535 HB, TiSi, Ø DC / R1: 10/0,5mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 206353 10/0,5 |
| GTIN         | 4045197540287 |
| Item class   | 12X           |

### Description

#### Version:

Dimensions to factory standard and 35° spiral.

#### Special TiSi coating.

With balancing speed G 2.5.

#### Note:

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 206348**

### Technical description

|  |                   |
|--|-------------------|
| Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>            | 0.052 mm          |
| Recess Ø $D_1$   | 9.7 mm            |
| Corner radius $R_1$  | 0.5 mm            |
| Overhang length $L_1$ incl. recess                                     | 30 mm             |
| Cutting edge Ø $D_c$   | 10 mm             |
| No. of teeth $Z$   | 4                 |
| Feed $f_z$ for copy milling in stainless steel > 900 N/mm <sup>2</sup> | 0.064 mm          |
| Shank Ø $D_s$  | 10 mm             |
| Flute length $L_c$   | 22 mm             |
| Overall length $L$   | 72 mm             |
| Shank  | DIN 6535 HB to h6 |

|   |                                  |
|---|----------------------------------|
| Helix angle                               | 35 degrees                       |
| Coating                                   | TiSi                             |
| Tool material                             | Solid carbide                    |
| Standard                                  | Manufacturer's standard          |
| Type                                      | N                                |
| 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 | 0.05×D for copy milling          |
| Through-coolant                           | no                               |
| Machining strategy                        | HPC                              |
| Shank tolerance                           | h6                               |
| Colour ring                               | blue                             |
| Type of product                           | Torus cutter                     |

## User data

|                                | Suitability | $V_c$     | ISO code |
|--------------------------------|-------------|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 250 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 230 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 200 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 180 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 170 m/min | P        |
| TOOLOX 33                      | suitable    | 115 m/min | H        |
| TOOLOX 44                      | suitable    | 80 m/min  | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 90 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 80 m/min  | M        |

|             |   |
|-------------|---|
| Uni         | suitable only under restricted conditions |
| wet maximum | suitable                                  |
| wet minimum | Suitable                                  |
| dry         | Suitable only under restricted conditions |
| Air         | suitable only under restricted conditions |