


**Solid carbide torus cutter HPC DIN 6535 HB, TiSi, Ø DC / R1: 20/4,0mm**

**Order data**

Order number	206353 20/4,0
GTIN	4045197540409
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 copy milling in stainless steel $> 900 \text{ N/mm}^2$	0.096 mm
No. of teeth Z	4
Overhang length $L_1$ incl. recess	52 mm
Recess $\varnothing D_1$	19.5 mm
Cutting edge $\varnothing D_c$	20 mm
Feed $f_z$ for side milling in INOX $> 900 \text{ N/mm}^2$	0.078 mm
Corner radius $R_1$	4 mm
Shank $\varnothing D_s$	20 mm
Flute length $L_c$	41 mm
Overall length L	104 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