


Solid carbide torus cutter HPC DIN 6535 HB, TiSi, Ø DC / R1: 4/0,5mm

Order data

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|--------------|---------------|
| Order number | 206353 4/0,5 |
| GTIN | 4045197540171 |
| 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

| | |
|---|-------------------|
| Recess Ø D ₁ | 3.8 mm |
| Corner radius R ₁ | 0.5 mm |
| Feed f _z for side milling in INOX > 900 N/mm ² | 0.014 mm |
| Cutting edge Ø D _c | 4 mm |
| Feed f _z for copy milling in stainless steel > 900 N/mm ² | 0.018 mm |
| No. of teeth Z | 4 |
| Overhang length L ₁ incl. recess | 17 mm |
| Shank Ø D _s | 6 mm |
| Flute length L _c | 11 mm |
| Overall length L | 57 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 ² | suitable | 250 m/min | P |
| Steel < 750 N/mm ² | suitable | 230 m/min | P |
| Steel < 900 N/mm ² | suitable | 200 m/min | P |
| Steel < 1100 N/mm ² | suitable | 180 m/min | P |
| Steel < 1400 N/mm ² | suitable | 170 m/min | P |
| TOOLOX 33 | suitable | 115 m/min | H |
| TOOLOX 44 | suitable | 80 m/min | H |
| INOX < 900 N/mm ² | suitable | 90 m/min | M |
| INOX > 900 N/mm ² | 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 |