

Garant
**PCD torus cutter with internal cooling straight cut, PCD, Ø e8 DC / R1:
5/0,5mm**

Order data

| | |
|--------------|---------------|
| Order number | 209804 5/0,5 |
| GTIN | 4062406765347 |
| Item class | 100 |

Description
Version:

High performance PCD slot drill for high metal removal rates.

Straight flutes for a neutral cut.

Tolerance for corner radius $R_1 = \pm 0.01$ mm.

Technical description

| | |
|---|-------------------|
| Feed f_z for side milling in cast aluminium | 0.04 mm |
| Feed f_z for side milling in graphite | 0.07 mm |
| No. of teeth Z | 2 |
| Cutting edge Ø D_c | 5 mm |
| Feed f_z for copy milling in cast aluminium | 0.07 mm |
| Recess Ø D_1 | 4.6 mm |
| Overall length L | 54 mm |
| Feed f_z for copy milling in graphite | 0.12 mm |
| Shank | DIN 6535 HA to h6 |
| Flute length L_c | 3 mm |
| Shank Ø D_s | 6 mm |
| Corner radius R_1 | 0.5 mm |

| | |
|---|----------------------------------|
| Overhang length L_1 incl. recess | 18 mm |
| Coating | PCD |
| Tool material | PCD |
| Standard | Manufacturer's standard |
| 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 | yes |
| Shank tolerance | h6 |
| Colour ring | black |
| Type of product | Torus cutter |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|------------|----------|
| Aluminium | suitable | 2400 m/min | N |
| Aluminium (short chipping) | suitable | 2000 m/min | N |
| Alu > 10% Si | suitable | 1500 m/min | N |
| PMMA acrylic | suitable | 1000 m/min | N |
| PE-HD | suitable | 900 m/min | N |
| PA 66 | suitable | 900 m/min | N |
| PEEK | suitable | 800 m/min | N |
| PVDF GF20 | suitable | 1200 m/min | N |
| POM GF25 | suitable | 1200 m/min | N |
| PA 66 GF30 | suitable | 1000 m/min | N |
| PEEK GF30 | suitable | 1000 m/min | N |
| PTFE CF25 | suitable | 1000 m/min | N |
| PEEK CF30 | suitable | 800 m/min | N |

| | | | |
|-----------------|----------|-----------|---|
| Hybrids | suitable | | |
| MMC | suitable | 400 m/min | N |
| GRP | suitable | 500 m/min | N |
| CRP | suitable | 500 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| dry | Suitable | | |
| Air | suitable | | |
| Services | | | |

Shank grinding Type HB

129100 HB