

**Garant**
**PCD torus cutter with internal cooling straight cut, PCD, Ø e8 DC / R1:  
10/1,0mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 209804 10/1,0 |
| GTIN         | 4062406765392 |
| 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**

|   |                   |
|---|-------------------|
| Recess Ø $D_1$                                | 9.2 mm            |
| Overall length L                              | 72 mm             |
| Feed $f_z$ for copy milling in cast aluminium | 0.09 mm           |
| Feed $f_z$ for side milling in graphite       | 0.1 mm            |
| Shank Ø $D_s$                                 | 10 mm             |
| Cutting edge Ø $D_c$                          | 10 mm             |
| Corner radius $R_1$                           | 1 mm              |
| Feed $f_z$ for copy milling in graphite       | 0.14 mm           |
| Flute length $L_c$                            | 8 mm              |
| Overhang length $L_1$ incl. recess            | 32 mm             |
| Shank   | DIN 6535 HA to h6 |
| No. of teeth Z                                | 2                 |

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for side milling in cast aluminium | 0.06 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 |           |   |
| <b>Services</b> |          |           |   |

Shank grinding Type HB

129100 HB