

Garant
PCD torus cutter with internal cooling 209804, PCD, Ø e8 DC / R1: 4/0,5mm

Order data

Order number	209635 4/0,5
GTIN	4045197513397
Item class	11Y

Description
Version:

High performance PCD slot drill for the **highest demands in respect to material removal rates** when machining **GRP, CRP** and **graphite**.

Straight flutes for a neutral cut.

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

No. of teeth Z: 2

Shank: DIN 6535 HA to h6

No. of teeth Z: 2

Flute length L_c : 2.5 mm

Corner radius R_1 : 0.5 mm

Overhang length L_1 incl. recess: 14 mm

Recess Ø D_1 : 3.8 mm

Overall length L: 50 mm

Technical description

Corner radius R_1	0.5 mm
Cutting edge Ø D_c	4 mm
Feed f_z for copy milling in GRP CRP	0.05 mm
Feed f_z for side milling in graphite	0.06 mm
Feed f_z for side milling in GRP CRP	0.03 mm
Recess Ø D_1	3.8 mm
Feed f_z for copy milling in graphite	0.1 mm
No. of teeth Z	2

Overhang length L_1 incl. recess	14 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	2.5 mm
Overall length L	50 mm
Shank	DIN 6535 HA to h6
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