Garant

Solid carbide torus cutter, Diamond, ∅ e8 DC / R1: 4/1,0mm

Order data

Order number	209750 4/1,0
GTIN	4045197475138
Item class	10Y

Description

Version:
With the latest generation of **crystalline diamond coating sp**^{3} for process reliability in machining **fibre-reinforced composites, CRP, GRP and graphite.** Double relief ground side clearance angle.
For copy milling with angle α = 1°30′.
Tolerance: corner radius **R_1= ±0.01 mm.**
Note:
Standard application values
Side milling: f_z for a_p= 0.1×D.

Technical description

Recess ∅ D_1	3.8 mm
∅ D_2	5.1 mm
Feed f_z for side milling in graphite	0.026 mm
Cutting edge ∅ D_C	4 mm
Corner radius R_1	1 mm
No. of teeth Z	2
L_2	40 mm
Overhang length L_1 incl. recess	16 mm
Feed f_z for copy milling in graphite	0.034 mm
Shank ∅ D_s	6 mm

Flute length L_c	3 mm
Overall length L	80 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal ∅	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	0.5×D for side milling
Through-coolant	no
Shank tolerance	h6
Colour ring	black
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
PVDF GF20	suitable	200 m/min	N
POM GF25	suitable	190 m/min	N
PA 66 GF30	suitable	170 m/min	N
PEEK GF30	suitable	150 m/min	N
PTFE CF25	suitable	180 m/min	N
PEEK CF30	suitable	160 m/min	N
Hybrids	suitable		
Honeycomb sandwich	suitable	350 m/min	N
GRP	suitable	190 m/min	N
GRP, CRP	suitable	190 m/min	N
Graphite	suitable	340 m/min	N

wet minimum	suitable
dry	Suitable
Air	suitable

Services

Shank grinding Type HB	129100 HB