

Garant
Solid carbide torus cutter, Diamond, Ø e8 DC / R1: 1/0,25mm

Order data

Order number	209750 1/0,25
GTIN	4045197475060
Item class	11Y

Description
Version:

With the latest generation of **crystalline diamond coating sp³** for process reliability in machining **fibre-reinforced composites, CRP, GRP and graphite**. Double relief ground side clearance angle.

For copy milling with angle $\alpha = 1^{\circ}30'$.

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

Note:

Standard application values

Side milling: f_z for $a_p = 0.1 \times D$.

Technical description

Cutting edge Ø D _c	1 mm
Recess Ø D ₁	0.85 mm
Corner radius R ₁	0.25 mm
Ø D ₂	2.7 mm
Overhang length L ₁ incl. recess	4 mm
Feed f_z for copy milling in graphite	0.016 mm
Feed f_z for side milling in graphite	0.0113 mm
L ₂	40 mm
No. of teeth Z	2
Shank Ø D _s	6 mm

Flute length L_c	2 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 \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	0.5×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