

**Garant**
**Solid carbide torus cutter, Diamond, Ø e8 DC / R1: 1,5/0,15mm**

**Order data**

Order number	209750 1,5/0,15
GTIN	4045197475084
Item class	11Y

**Description**
**Version:**

With the latest generation of **crystalline diamond coating sp<sup>3</sup>** 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**

No. of teeth Z	2
Feed $f_z$ for side milling in graphite	0.02 mm
Cutting edge Ø $D_c$	1.5 mm
$L_2$	27 mm
Ø $D_2$	2.7 mm
Feed $f_z$ for copy milling in graphite	0.028 mm
Corner radius $R_1$	0.15 mm
Overhang length $L_1$ incl. recess	3 mm
Recess Ø $D_1$	1.45 mm
Shank Ø $D_s$	3 mm

Flute length $L_c$	1.8 mm
Overall length $L$	75 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