

Garant
Solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 2mm

Order data

| | |
|--------------|---------------|
| Order number | 206267 2 |
| GTIN | 4045197858023 |
| Item class | 11X |

Description
Version:

Special centre cutting edge geometry for traverse milling at very high feed rates.

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

Application:

For copy and traverse milling over the full range of hard machining **under HPC/HSC conditions.**

Using special milling strategies **very high rates of metal removal can be achieved.**

Note:

Successor product to No. 206274.

Tools can be reground.

Technical description

| | |
|---|----------|
| Programming radius | 0.3 mm |
| Flute length L_c | 1.5 mm |
| Cutting edge $\varnothing D_c$ | 2 mm |
| Overhang length L_1 incl. recess | 18 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Recess $\varnothing D_1$ | 1.7 mm |
| Feed f_z in steel < 900 N/mm ² | 0.019 mm |
| Dimension $a_{p\ max}$ transverse | 0.15 mm |
| No. of teeth Z | 2 |
| Overall length L | 75 mm |

| | |
|---|--------------------------------------|
| Setting angle κ | 11 degrees |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | N |
| Tolerance nominal \varnothing | h9 |
| Helix angle | 15 degrees |
| Direction of infeed | horizontal and oblique |
| Cutting width a_e for milling operation | Full slot cutting depth $1 \times D$ |
| Shank | DIN 6535 HA to h5 |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | End torus mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 150 m/min | P |
| Steel < 750 N/mm ² | suitable | 140 m/min | P |
| Steel < 900 N/mm ² | suitable | 130 m/min | P |
| Steel < 1100 N/mm ² | suitable | 125 m/min | P |
| Steel < 1400 N/mm ² | suitable | 115 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 80 m/min | M |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| dry | suitable only under restricted conditions | | |

Air

suitable only under
restricted conditions

Services

Shank grinding Type HB

129100 HB