

## Garant

### Solid carbide torus cutter, DLC, Ø h6 DC / R1: 8/1,0mm



## Order data

Order number	206230 8/1,0
GTIN	4045197860255
Item class	11X

## Description

### Version:

With the latest generation of **DLC coating sp<sup>2</sup>**.

**Eccentric relief ground**, additionally **polish ground** in the flutes for **outstanding chip evacuation** in long-chipping aluminium components.

Tolerances:

- **Corner radius**

**R<sub>1</sub> = 0.5 tolerance ±0.02.**

**R<sub>1</sub> > 0.5 – 1.5 tolerance ±0.03.**

**R<sub>1</sub> > 1.5 tolerance ±0.05.**

### Note:

**NEW GENERATION AVAILABLE! Recommended successor product is No. 206255.**

## Technical description

Overhang length L <sub>1</sub> incl. recess	25 mm
Recess Ø D <sub>1</sub>	7.4 mm
Balance quality with shank	G 2.5 with HA
Shank	DIN 6535 HA to h6
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.04 mm
Shank Ø D <sub>s</sub>	8 mm
Corner radius R <sub>1</sub>	1 mm
Flute length L <sub>c</sub>	21 mm
Feed f <sub>z</sub> for copy milling in short-chipping aluminium	0.04 mm

Cutting edge $\varnothing D_c$	8 mm
Overall length L	63 mm
No. of teeth Z	3
Helix angle	45 degrees
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Tolerance nominal $\varnothing$	h6
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	0.5×D for side milling
Cutting width $a_e$ for milling operation	0.05×D for copy milling
Through-coolant	no
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	suitable	200 m/min	N
PE-HD	suitable	160 m/min	N
PA 66	suitable	200 m/min	N
PEEK	suitable	150 m/min	N
PF 31	suitable	130 m/min	N
PVDF GF20	suitable	180 m/min	N

POM GF25	suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	Suitable		
<b>Services</b>			

Shank grinding Type HB

129100 HB