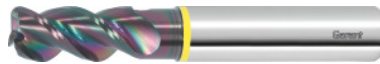


## Garant

### Solid carbide torus cutter, DLC, Ø h6 DC / R1: 20/4,0mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 206230 20/4,0 |
| GTIN         | 4045197860408 |
| 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

|  |               |
|--|---------------|
| Overall length L   | 104 mm        |
| No. of teeth Z   | 3             |
| Corner radius R <sub>1</sub>                                     | 4 mm          |
| Feed f <sub>z</sub> for copy milling in short-chipping aluminium | 0.13 mm       |
| Feed f <sub>z</sub> for side milling in short-chipping aluminium | 0.12 mm       |
| Shank Ø D <sub>s</sub>   | 20 mm         |
| Balance quality with shank                                       | G 2.5 with HA |
| Recess Ø D <sub>1</sub>  | 19 mm         |
| Flute length L <sub>c</sub>                                      | 41 mm         |

|   |                                  |
|---|----------------------------------|
| Shank                                     | DIN 6535 HA to h6                |
| Overhang length $L_1$ incl. recess        | 52 mm                            |
| Cutting edge $\varnothing D_c$            | 20 mm                            |
| 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