

## Garant

### Solid carbide torus cutter, DLC, Ø h6 DC / R1: 12/0,5mm



#### Order data

Order number	206250 12/0,5
GTIN	4045197860514
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.

Dimensions to manufacturer's standard.

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. 206261.**

#### Technical description

Feed $f_z$ for side milling in short-chipping aluminium	0.07 mm
Flute length $L_c$	19 mm
Recess $\varnothing D_1$	11 mm
No. of teeth $Z$	3
Overall length $L$	120 mm
Balance quality with shank	G 2.5 with HA
Corner radius $R_1$	0.5 mm
Shank	DIN 6535 HA to h6

Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Overhang length $L_1$ incl. recess	73 mm
Feed $f_z$ for copy milling in short-chipping aluminium	0.08 mm
Helix angle	45 degrees
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Tolerance nominal $\varnothing$	h6
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	0.3×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	280 m/min	N
Aluminium (short chipping)	suitable	260 m/min	N
Alu > 10% Si	suitable	240 m/min	N
PMMA acrylic	suitable	120 m/min	N
PE-HD	suitable	100 m/min	N
PA 66	suitable	120 m/min	N
PEEK	suitable	90 m/min	N
PF 31	suitable	80 m/min	N

PVDF GF20	suitable	110 m/min	N
POM GF25	suitable	100 m/min	N
PA 66 GF30	suitable	90 m/min	N
PEEK GF30	suitable	80 m/min	N
PTFE CF25	suitable	90 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	suitable	100 m/min	N
CuZn	suitable	120 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
<del>Air</del>	<del>Suitable</del>		
<b>Services</b>			

Shank grinding Type HB

129100 HB