

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

**Order data**

Order number	206250 20/4,0
GTIN	4045197860606
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**

Flute length L <sub>c</sub>	32 mm
Shank	DIN 6535 HA to h6
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.12 mm
Shank Ø D <sub>s</sub>	20 mm
Cutting edge Ø D <sub>c</sub>	20 mm
No. of teeth Z	3
Overhang length L <sub>1</sub> incl. recess	98 mm
Recess Ø D <sub>1</sub>	19 mm

Overall length L	150 mm
Corner radius R <sub>1</sub>	4 mm
Feed f <sub>z</sub> for copy milling in short-chipping aluminium	0.13 mm
Balance quality with shank	G 2.5 with HA
Helix angle	45 degrees
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Tolerance nominal Ø	h6
Direction of infeed	horizontal, oblique and vertical
Cutting width a <sub>e</sub> for milling operation	0.3×D for side milling
Cutting width a <sub>e</sub> 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 <sub>c</sub>	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