

Garant
Solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 8mm

Order data

Order number	206266 8
GTIN	4045197860651
Item class	11X

Description
Version:

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

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

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. 206272.

Tools can be reground.

Technical description

Programming radius	1.5 mm
Shank $\varnothing D_s$	8 mm
Feed f_z in steel $< 900 \text{ N/mm}^2$	0.158 mm
Overhang length L_1 incl. recess	24 mm
Cutting edge $\varnothing D_c$	8 mm
No. of teeth Z	4
Dimension $a_{p \text{ max}}$ transverse	0.5 mm
Overall length L	70 mm
Flute length L_c	4.8 mm

Recess $\varnothing D_1$	7 mm
Setting angle κ	15 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	155 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	145 m/min	P
Steel < 1100 N/mm ²	suitable	140 m/min	P
Steel < 1400 N/mm ²	suitable	130 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	90 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

dry	suitable only under restricted conditions
Air Services	suitable only under restricted conditions
Shank grinding Type HB	129100 HB