

Garant
Solid carbide torus cutter R1 0.1, Diamond, Ø DC × L1: 0,8X10mm

Order data

| | |
|--------------|---------------|
| Order number | 209716 0,8X10 |
| GTIN | 4045197918178 |
| Item class | 11Y |

Description
Version:

With **crystalline diamond sp³ coating**. For the **highest demands regarding performance and precision** in fibre-reinforced composites, CRP, GRP, and graphite. **Extremely tight tolerances** ensure maximum accuracy. Double relief ground with 2 hollow-ground chamfers. **Recess angle $\alpha = 16^\circ$** .

Tolerances:

- **Corner radius: $R_1 = \pm 0.0025$ mm**
- **Neck Ø: $D_1 = 0 / -0.01$ mm**

Note:

At greater tool overhang lengths, use a reduced value for a_p !

Values for:

copying: $a_p = 0.10 \times D \times a_{p, \text{korr}}$

side milling: $a_p = 0.20 \times D \times a_{p, \text{korr}}$

To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)!

e.g: $vf = 18000$ [rpm] × fz [mm/Z] × z

Technical description

| | |
|------------------------------------|---------|
| Recess Ø D_1 | 0.78 mm |
| Cutting edge Ø D_c | 0.8 mm |
| No. of teeth Z | 2 |
| Shank Ø D_s | 4 mm |
| Overhang length L_1 incl. recess | 10 mm |
| Flute length L_c | 0.8 mm |

| | |
|----------------------------------------------------|----------------------------------|
| Overall length L | 50 mm |
| Corner radius R ₁ | 0.1 mm |
| Shank | DIN 6535 HA to h5 |
| Feed f _z for copy milling in graphite | 0.016 mm |
| Feed f _z for side milling in graphite | 0.016 mm |
| Helix angle | 25 degrees |
| Correction factor a _{p,corr} | 0.35 |
| Coating | Diamond |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Tolerance nominal Ø | 0 / -0.005 |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting width a _e for milling operation | 0.05×D for copy milling |
| Cutting width a _e for milling operation | 0.5×D for side milling |
| Through-coolant | no |
| Colour ring | black |
| Type of product | Torus cutter |

User data

| | Suitability | V _c | ISO code |
|--------------------|-------------|----------------|----------|
| PVDF GF20 | suitable | 200 m/min | N |
| POM GF25 | suitable | 190 m/min | N |
| PA 66 GF30 | suitable | 170 m/min | N |
| PEEK GF30 | suitable | 150 m/min | N |
| PTFE CF25 | suitable | 180 m/min | N |
| PEEK CF30 | suitable | 160 m/min | N |
| Hybrids | suitable | | |
| Honeycomb sandwich | suitable | 350 m/min | N |
| GRP | suitable | 190 m/min | N |

| | | | |
|-------------|----------|-----------|---|
| GRP, CRP | suitable | 190 m/min | N |
| Graphite | suitable | 340 m/min | N |
| wet minimum | suitable | | |
| dry | suitable | | |
| Air | suitable | | |