Garant

Solid carbide torus cutter, Diamond, ∅ e8 DC / R1: 8/0,5mm

Order data

Order number	209760 8/0,5
GTIN	4045197507358
Item class	10Y

Description

Version:
With the latest generation of **crystalline diamond coating sp**^{3}, for process reliability in machining **fibre-reinforced composites, CRP, GRP and graphite.** Double relief ground side clearance angle.
Tolerance: **Corner radius R_1 = ±0.01 mm.**

Technical description

Overhang length L_1 incl. recess	75 mm
Cutting edge ∅ D_C	8 mm
Feed f_z for side milling in graphite	0.078 mm
Feed f_z for copy milling in graphite	0.078 mm
Recess ∅ D_1	7.4 mm
No. of teeth Z	4
Corner radius R_1	0.5 mm
Shank ∅ D_s	8 mm
Flute length L_c	9 mm
Overall length L	120 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Coating	Diamond

Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal ∅	e8
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.2×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	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		

Services

Shank grinding Type HB	129100 HB