

**Garant**
**Solid carbide torus cutter, DLC, Ø e8 DC / R1: 4/1,0mm**

**Order data**

Order number	206065 4/1,0
GTIN	4062406074715
Item class	11X

**Description**
**Version:**

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

With the latest generation of **DLC coating sp<sup>2</sup>**.

With **double relief ground side clearance angle and corner radius**.

**High strength** due to **strengthened core**.

**Technical description**

Helix angle	30 degrees
No. of teeth Z	2
Overall length L	50 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.02 mm
Corner radius $R_1$	1 mm
Shank	DIN 6535 HA to h6
Overhang length $L_1$ incl. recess	16 mm
Feed $f_z$ for copy milling in short-chipping aluminium	0.023 mm
Shank Ø $D_s$	4 mm
Recess Ø $D_1$	3.7 mm
Cutting edge Ø $D_c$	4 mm
Flute length $L_c$	5 mm
Coating	DLC

Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Tolerance nominal $\varnothing$	e8
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
Shank tolerance	h6
Colour ring	yellow
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	330 m/min	N
Aluminium (short chipping)	suitable	300 m/min	N
Alu > 10% Si	suitable	230 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	Suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	Suitable	150 m/min	N
PEEK GF30	Suitable	130 m/min	N
PTFE CF25	Suitable	160 m/min	N

Honeycomb sandwich	suitable only under restricted conditions	300 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		
Air	Suitable		