

Garant
Solid carbide torus cutter, Diamond, Ø e8 DC / R1: 12/2,0mm

Order data

| | |
|--------------|---------------|
| Order number | 209760 12/2,0 |
| GTIN | 4045197507396 |
| Item class | 10Y |

Description
Version:

With the latest generation of **crystalline diamond coating sp³**, for process reliability in machining **fibre-reinforced composites, CRP, GRP and graphite**. Double relief ground side clearance angle.

Tolerance: **Corner radius R₁ = ±0.01 mm.**

Technical description

| | |
|---|-------------------|
| Feed f_z for copy milling in graphite | 0.105 mm |
| Feed f_z for side milling in graphite | 0.105 mm |
| Cutting edge Ø D _c | 12 mm |
| Corner radius R ₁ | 2 mm |
| Recess Ø D ₁ | 11 mm |
| No. of teeth Z | 4 |
| Overhang length L ₁ incl. recess | 100 mm |
| Shank Ø D _s | 12 mm |
| Flute length L _c | 12 mm |
| Overall length L | 160 mm |
| Shank | DIN 6535 HA to h6 |
| Helix angle | 30 degrees |
| Coating | Diamond |

| | |
|---|----------------------------------|
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Tolerance nominal \varnothing | 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