

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

Order data

Order number	209758 4/1,0
GTIN	4045197475473
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 $R_1 = \pm 0.01$ mm.

Technical description

Cutting edge Ø D_c	4 mm
Overhang length L_1 incl. recess	36 mm
Feed f_z for side milling in graphite	0.02 mm
Feed f_z for copy milling in graphite	0.02 mm
No. of teeth Z	4
Recess Ø D_1	3.7 mm
Corner radius R_1	1 mm
Shank Ø D_s	4 mm
Flute length L_c	5 mm
Overall length L	75 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	$0.2 \times D$ for side milling
Cutting width a_e for milling operation	$0.05 \times D$ 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		

