

Garant**Solid carbide torus cutter, Diamond, Ø e8 DC / R1: 12/1,0mm****Order data**

Order number	209755 12/1,0
GTIN	4045197475398
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 $R_1 = \pm 0.01$ mm.

Technical description

Feed f_z for side milling in graphite	0.105 mm
Overhang length L_1 incl. recess	38 mm
No. of teeth Z	4
Recess Ø D_1	11 mm
Corner radius R_1	1 mm
Feed f_z for copy milling in graphite	0.105 mm
Cutting edge Ø D_c	12 mm
Shank Ø D_s	12 mm
Flute length L_c	12 mm
Overall length L	83 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		

Services

Shank grinding Type HB

129100 HB