

Garant
Solid carbide torus cutter R1 0.1, Diamond, Ø DC × L1: 0,4X4 mm

Order data

Order number	209716 0,4X4
GTIN	4045197917997
Item class	11Y

Description
Version:

With **crystalline diamond sp³ coating**. For the **highest demands regarding performance and precision** in fibre-reinforced composites, CRP, GRP, and graphite. **Extremely tight tolerances** ensure maximum accuracy. Double relief ground with 2 hollow-ground chamfers. **Recess angle $\alpha = 16^\circ$** .

Tolerances:

- **Corner radius: $R_1 = \pm 0.0025$ mm**
- **Neck Ø: $D_1 = 0 / -0.01$ mm**

Note:

At greater tool overhang lengths, use a reduced value for a_p !

Values for:

copying: $a_p = 0.10 \times D \times a_{p, \text{korr}}$

side milling: $a_p = 0.20 \times D \times a_{p, \text{korr}}$

To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)!

e.g: $vf = 18000$ [rpm] × fz [mm/Z] × z

No. of teeth Z : 2

Helix angle: 25 degrees

Shank: DIN 6535 HA to h5

No. of teeth Z : 2

Flute length L_c : 0.4 mm

Corner radius R_1 : 0.1 mm

Overhang length L_1 incl. recess: 4 mm

Recess Ø D_1 : 0.38 mm

Overall length L : 50 mm

Technical description

Corner radius R_1	0.1 mm
Flute length L_c	0.4 mm
Overall length L	50 mm
Feed f_z for copy milling in graphite	0.012 mm
No. of teeth Z	2
Feed f_z for side milling in graphite	0.012 mm
Shank $\varnothing D_s$	4 mm
Overhang length L_1 incl. recess	4 mm
Shank	DIN 6535 HA to h5
Cutting edge $\varnothing D_c$	0.4 mm
Recess $\varnothing D_1$	0.38 mm
Helix angle	25 degrees
Correction factor $a_{p\text{corr}}$	0.5
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal \varnothing	0 / -0.005
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
Colour ring	black
Type of product	End mill