

## Garant

### Solid carbide torus cutter R1 0.1, Diamond, Ø DC × L1: 0,4X6 mm



#### Order data

Order number	209716 0,4X6
GTIN	4045197918000
Item class	11Y

#### Description

##### Version:

With **crystalline diamond sp<sup>3</sup> 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: 6 mm

Recess Ø  $D_1$ : 0.38 mm

Overall length  $L$ : 50 mm

#### Technical description

Overall length L	50 mm
Recess $\varnothing D_1$	0.38 mm
Feed $f_z$ for side milling in graphite	0.012 mm
Overhang length $L_1$ incl. recess	6 mm
Shank $\varnothing D_s$	4 mm
Feed $f_z$ for copy milling in graphite	0.012 mm
Flute length $L_c$	0.4 mm
Corner radius $R_1$	0.1 mm
Shank	DIN 6535 HA to h5
Cutting edge $\varnothing D_c$	0.4 mm
No. of teeth Z	2
Helix angle	25 degrees
Correction factor $a_{p\text{corr}}$	0.2
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