

Garant
GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 10mm

Order data

Order number	203382 10
GTIN	4045197597625
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide, specially for hard machining.

Application:

For profile milling as finishing.

(Plunge cutting only to shallow depths).

Technical description

Feed f_z for side milling in steel < 65 HRC	0.018 mm
No. of teeth Z	6
Overhang length L_1 incl. recess	60 mm
Cutting edge Ø D_c	10 mm
Recess Ø D_1	9.7 mm
Shank Ø D_s	10 mm
Overall length L	100 mm
Flute length L_c	25 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Helix angle	50 degrees

Corner chamfer angle	90 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Cutting width a_e for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm ²	suitable	120 m/min	P
Steel < 50 HRC	suitable	115 m/min	H
Steel < 55 HRC	suitable	100 m/min	H
Steel < 60 HRC	suitable	90 m/min	H
Steel < 65 HRC	suitable	60 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB	129100 HB
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