

Garant
**GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1:
20/1,0mm**

Order data

Order number	206442 20/1,0
GTIN	4045197599506
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Dimensions to DIN 6527 and 45° flutes.

Tolerance: Corner radius $R_1 = \pm 0.005$ mm.

Application:

For peripheral milling as a **finishing operation** (plunge milling only to shallow depths).

Technical description

Cutting edge $\varnothing D_c$	20 mm
Corner radius R_1	1 mm
No. of teeth Z	10
Feed f_z for side milling in steel < 65 HRC	0.03 mm
Shank $\varnothing D_s$	20 mm
Flute length L_c	60 mm
Overall length L	126 mm
Shank	DIN 6535 HA to h6
Helix angle	45 degrees
Series	Diabolo
Coating	TiAlN

Tool material	Solid carbide
Standard	DIN 6527
Type	H
Tolerance nominal \varnothing	e8
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal and oblique
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.05×D for side milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	red
Type of product	Torus cutter

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm ²	suitable	150 m/min	P
Steel < 50 HRC	suitable	150 m/min	H
Steel < 55 HRC	suitable	150 m/min	H
Steel < 60 HRC	suitable	125 m/min	H
Steel < 65 HRC	suitable	80 m/min	H
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

Services

Shank grinding Type HB	129100 HB
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