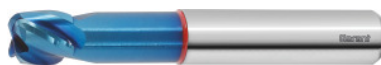


Garant
GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 8/1,0mm

Order data

Order number	206322 8/1,0
GTIN	4045197598325
Item class	11X

Description
Version:
GARANT Diabolo:

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

Double relief ground side clearance angle.

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

Technical description

Recess Ø D_1	7.4 mm
Feed f_z for side milling in steel < 65 HRC	0.06 mm
Feed f_z for copy milling in steel < 65 HRC	0.06 mm
No. of teeth Z	4
Corner radius R_1	1 mm
Cutting edge Ø D_c	8 mm
Overhang length L_1 incl. recess	27 mm
Shank Ø D_s	8 mm
Flute length L_c	9 mm
Overall length L	63 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Series	Diabolo

Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal Ø	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
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	200 m/min	P
Steel < 50 HRC	suitable	190 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	150 m/min	H
Steel < 65 HRC	suitable	110 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