

Garant
GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 2mm

Order data

| | |
|--------------|---------------|
| Order number | 203211 2 |
| GTIN | 4045197597366 |
| Item class | 11X |

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide, specially for hard machining.
Dimensions similar to DIN 6527.

Application:

For profile milling as finishing.

(Plunge cutting only to shallow depths).

Technical description

| | |
|---|------------------------|
| Feed f_z for side milling in steel < 65 HRC | 0.016 mm |
| No. of teeth Z | 4 |
| Cutting edge $\varnothing D_c$ | 2 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 57 mm |
| Flute length L_c | 8 mm |
| Direction of infeed | horizontal and oblique |
| Shank | DIN 6535 HA to h6 |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 50 degrees |
| Corner chamfer angle | 90 degrees |

| | |
|---|----------------------------------|
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| 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 | 170 m/min | P |
| Steel < 50 HRC | suitable | 170 m/min | H |
| Steel < 55 HRC | suitable | 170 m/min | H |
| Steel < 60 HRC | suitable | 145 m/min | H |
| Steel < 65 HRC | suitable | 100 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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