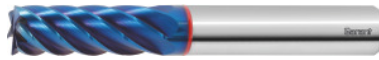


Garant
Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 18mm

Order data

Order number	203282 18
GTIN	4045197597540
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).

Tolerance nominal Ø: e8

No. of teeth Z: 8

Helix angle: 50°

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HA to h6

No. of teeth Z: 8

Flute length L_c : 54 mm

Overall length L: 114 mm

Shank Ø D_s : 18 mm

Feed f_z for side milling in steel < 65 HRC: 0.03 mm

Technical description

No. of teeth Z	8
Feed f_z for side milling in steel < 65 HRC	0.03 mm
Cutting edge Ø D_c	18 mm
Shank Ø D_s	18 mm
Overall length L	114 mm

Flute length L_c	54 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	e8
Helix angle	50°
Corner chamfer angle	90°
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×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 recess Type FRST	209900 FRST
Shank grinding Type HB	129100 HB