

Garant
Diabolo solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 2mm

Order data

Order number	206273 2
GTIN	4045197858030
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Tolerance: Corner radius $R_1 = \pm 0.01$ mm.

Special centre cutting edge geometry for traverse milling at very high feed rates.

Application:

For copy and traverse milling in hard machining **under HPC / HSC conditions**. Special milling strategies allow **very high metal removal rates**.

Note:

Successor product to No. 206276.

Tools can be reground.

No. of teeth Z: 2

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Dimension $a_{p\ max}$ transverse: 0.06 mm

Programming radius: 0.3 mm

Flute length L_c : 1.5 mm

Overhang length L_1 incl. recess: 13 mm

Recess $\varnothing D_1$: 1.7 mm

Technical description

Feed f_z in steel < 60 HRC	0.024 mm
Flute length L_c	1.5 mm
Dimension $a_{p\ max}$ transverse	0.06 mm
Overall length L	54 mm

Cutting edge $\varnothing D_c$	2 mm
Shank $\varnothing D_s$	6 mm
Recess $\varnothing D_1$	1.7 mm
Overhang length L_1 incl. recess	13 mm
Programming radius	0.3 mm
No. of teeth Z	2
Setting angle κ	10.5 °
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	h9
Helix angle	12 °
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	Full slot cutting depth 1xD
Shank	DIN 6535 HA to h5
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End torus mill

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm ²	suitable	190 m/min	P
Steel < 50 HRC	suitable	170 m/min	H
Steel < 55 HRC	suitable	150 m/min	H
Steel < 60 HRC	suitable	110 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