

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

**Order data**

Order number	206275 2
GTIN	4045197858047
Item class	11X

**Description**
**Version:**
**GARANT Diabolo:**

Special geometry, coating and carbide for hard machining.

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

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. 206278.**

**Tools can be reground.**

No. of teeth Z: 2

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

Programming radius: 0.3 mm

Flute length  $L_c$ : 1.5 mm

Overhang length  $L_1$  incl. recess: 18 mm

Recess  $\varnothing D_1$ : 1.7 mm

**Technical description**

Flute length $L_c$	1.5 mm
Programming radius	0.3 mm
Overhang length $L_1$ incl. recess	18 mm
Overall length L	75 mm

Recess $\varnothing D_1$	1.7 mm
Cutting edge $\varnothing D_c$	2 mm
No. of teeth Z	2
Feed $f_z$ in steel < 60 HRC	0.018 mm
Dimension $a_{p\max}$ transverse	0.06 mm
Shank $\varnothing D_s$	6 mm
Setting angle $\kappa$	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 <sup>2</sup>	suitable	160 m/min	P
Steel < 50 HRC	suitable	145 m/min	H
Steel < 55 HRC	suitable	130 m/min	H
Steel < 60 HRC	suitable	95 m/min	H
Steel < 65 HRC	suitable	70 m/min	H

wet maximum	suitable only under restricted conditions
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable
<b>Services</b>	
Shank grinding Type HB	129100 HB