

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

Order data

Order number	206342 1/0,1
GTIN	4045197598608
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 $R_1 = \pm 0.005 \text{ mm}$.

No. of teeth Z: 4

Helix angle: 30°

Shank: DIN 6535 HA to h6

No. of teeth Z: 4

Flute length L_c : 1.5 mm

Corner radius R_1 : 0.1 mm

Overhang length L_1 incl. recess: 20 mm

Recess $\varnothing D_1$: 0.85 mm

Overall length L: 75 mm

Technical description

Cutting edge $\varnothing D_c$	1 mm
Overhang length L_1 incl. recess	20 mm
Feed f_z for side milling in steel < 65 HRC	0.005 mm
Feed f_z for copy milling in steel < 65 HRC	0.005 mm
Corner radius R_1	0.1 mm
Recess $\varnothing D_1$	0.85 mm
No. of teeth Z	4

Shank $\varnothing D_s$	3 mm
Flute length L_c	1.5 mm
Overall length L	75 mm
Shank	DIN 6535 HA to h6
Helix angle	30°
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	e8
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D for copy milling
Cutting width a_e for milling operation	0.2×D for side 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	160 m/min	P
Steel < 50 HRC	suitable	150 m/min	H
Steel < 55 HRC	suitable	135 m/min	H
Steel < 60 HRC	suitable	120 m/min	H
Steel < 65 HRC	suitable	90 m/min	H

wet maximum	suitable only under restricted conditions
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable