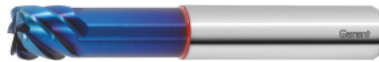


Garant
Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 6/0,5mm

Order data

Order number	206372 6/0,5
GTIN	4045197599025
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Tolerance: Corner radius $R_1 = \pm 0.005 \text{ mm}$.

Dimensions according to factory standard and 50° helix.

Double relief ground side clearance angle.

Without dynamic twist pitch.

No. of teeth Z: 6

Helix angle: 50°

Shank: DIN 6535 HA to h6

No. of teeth Z: 6

Flute length L_c : 7 mm

Corner radius R_1 : 0.5 mm

Overhang length L_1 incl. recess: 21 mm

Recess $\varnothing D_1$: 5.5 mm

Overall length L: 57 mm

Technical description

Recess $\varnothing D_1$	5.5 mm
Cutting edge $\varnothing D_c$	6 mm
Overhang length L_1 incl. recess	21 mm
No. of teeth Z	6
Feed f_z for copy milling in steel < 65 HRC	0.048 mm

Corner radius R_1	0.5 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	7 mm
Overall length L	57 mm
Shank	DIN 6535 HA to h6
Helix angle	50°
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal \varnothing	e8
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	0.05×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	200 m/min	P
Steel < 50 HRC	suitable	190 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	150 m/min	H
Steel < 65 HRC	suitable	110 m/min	H

wet maximum	suitable only under restricted conditions
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable
Services	
Shank recess Type FRST	209900 FRST
Shank grinding Type HB	129100 HB