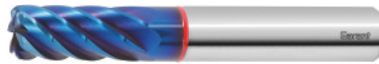


**Garant**
**Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 8/1,0mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 206422 8/1,0  |
| GTIN         | 4045197599285 |
| Item class   | 11X           |

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

Special geometry, coating and carbide for hard machining.

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

Tolerance: Corner radius  $RS_1 = \pm 0.005 \text{ mm}$ .

**Application:**

**For peripheral milling** as a **finishing operation** (plunge milling only to shallow depths).

No. of teeth Z: 6

Helix angle:  $45^\circ$

Shank: DIN 6535 HA to h6

No. of teeth Z: 6

Flute length  $L_c$ : 19 mm

Corner radius  $R_1$ : 1 mm

Overall length L: 63 mm

Shank  $\varnothing D_s$ : 8 mm

Feed  $f_z$  for side milling in steel < 65 HRC: 0.018 mm

**Technical description**

|   |          |
|---|----------|
| Cutting edge $\varnothing D_c$                | 8 mm     |
| No. of teeth Z                                | 6        |
| Feed $f_z$ for side milling in steel < 65 HRC | 0.018 mm |
| Corner radius $R_1$                           | 1 mm     |
| Shank $\varnothing D_s$                       | 8 mm     |

|   |                         |
|---|-------------------------|
| Flute length $L_c$                        | 19 mm                   |
| Overall length $L$                        | 63 mm                   |
| Shank                                     | DIN 6535 HA to h6       |
| Helix angle                               | 45 °                    |
| Series                                    | Diabolo                 |
| Coating                                   | TiAlN                   |
| Tool material                             | Solid carbide           |
| Standard                                  | DIN 6527                |
| Type                                      | H                       |
| Tolerance nominal $\varnothing$           | e8                      |
| Helix angle characteristic                | unequal spacing         |
| Direction of infeed                       | horizontal and oblique  |
| Cutting width $a_e$ for milling operation | 0.05×D for side milling |
| Cutting width $a_e$ for milling operation | 0.05×D for copy 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 <sup>2</sup> | 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 maximum                    | suitable only under restricted conditions |           |          |

|                 |   |
|-----------------|---|
| wet minimum     | suitable only under restricted conditions |
| dry             | suitable                                  |
| Air             | suitable                                  |
| <b>Services</b> |   |

|                        |             |
|------------------------|-------------|
| Shank recess Type FRST | 209900 FRST |
| Shank grinding Type HB | 129100 HB   |