

Garant
Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 12/1,0 mm

Order data

Order number	206442 12/1,0
GTIN	4045197599476
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Dimensions to DIN 6527 and 45° flutes.

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

Application:

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

No. of teeth Z: 6

Helix angle: 45 degrees

Shank: DIN 6535 HA to h6

No. of teeth Z: 6

Flute length L_c : 36 mm

Corner radius R_1 : 1 mm

Overall length L: 93 mm

Shank Ø D_s : 12 mm

Feed f_z for side milling in steel < 65 HRC: 0.023 mm

Technical description

Feed f_z for side milling in steel < 65 HRC	0.023 mm
No. of teeth Z	6
Cutting edge Ø D_c	12 mm
Corner radius R_1	1 mm
Shank Ø D_s	12 mm
Flute length L_c	36 mm

Overall length L	93 mm
Shank	DIN 6535 HA to h6
Helix angle	45 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Tolerance nominal Ø	e8
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal and oblique
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	End mill

Services

Shank recess Type FRST	209900 FRST
Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 12 mm	SZ2025 12
Shank grinding Type HB	129100 HB