

Garant
Solid carbide milling cutter HPC, TiAlN, Ø DC: 5 mm

Order data

Order number	203212 5
GTIN	4045197640789
Item class	11X

Description
Version:
GARANT Diabolo 70:

Special solid carbide substrate with extremely high tensile strength combined with **outstanding wear resistance** for optimum process reliability. Newly developed **nano-crystalline high-tech coating for hard milling up to 70 HRC**. Very suitable for **continuous use** in tool and mould making.

Sizes 2 – 5: **Recess angle $\alpha = 15^\circ$** .

Tolerance:

- **Size nominal Ø: $D_c \leq \text{size 12: } 0 / -0.02 \text{ mm;}$**
- **Size nominal Ø: D_c from size 16: $0 / -0.03 \text{ mm.}$**

Application:

Due to the **special hard geometry** ideal for use on hardened materials from 60 HRC to 70 HRC.

For profile milling as finishing.

(Plunge cutting only to shallow depths.)

Note:

For materials > 65 HRC: $a_e = 0.02 \times D$.

Machining strategy: HPC

Tolerance nominal Ø: $0 / -0.02$

No. of teeth Z: 6

Helix angle: 45 degrees

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HA to h6

No. of teeth Z: 6

Flute length L_c : 13 mm

Overall length L: 58 mm

Shank Ø D_s : 6 mm

Feed f_z for side milling in steel < 70 HRC: 0.018 mm

Technical description

Cutting edge $\varnothing D_c$	5 mm
No. of teeth Z	6
Feed f_z for side milling in steel < 70 HRC	0.018 mm
Shank $\varnothing D_s$	6 mm
Overall length L	58 mm
Flute length L_c	13 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	0 / -0.02
Helix angle	45 degrees
Corner chamfer angle	90 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Cutting width a_e for milling operation	0.05×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End mill

Services

Shank grinding Type HB	129100 HB
------------------------	-----------