

## Garant

### Solid carbide milling cutter HPC, TiAlN, Ø DC: 8 mm



#### Order data

Order number	203212 8
GTIN	4045197641007
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:  $D_c \leq$  size 12: 0 / -0.02 mm;**
- **Size nominal Ø:  $D_c$  from size 16: 0 / -0.03 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  $L_c$ : 19 mm

Overall length L: 64 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f_z$  for side milling in steel < 70 HRC: 0.025 mm

## Technical description

Cutting edge $\varnothing D_c$	8 mm
Feed $f_z$ for side milling in steel < 70 HRC	0.025 mm
No. of teeth Z	6
Shank $\varnothing D_s$	8 mm
Overall length L	64 mm
Flute length $L_c$	19 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 recess Type FRST	209900 FRST
Shank grinding Type HB	129100 HB