Garant

Diabolo solid carbide torus cutter R1 0.3, TiAlN, ⌀ DC × L1: 2X12 mm

Order data

Order number	206158 2X12
GTIN	4045197935236
Item class	11X

Description

Version:
GARANT Diabolo:
Special geometry, coating and carbide **for hard machining in the high-performance field.**
Suitable even for machining **electrolytic copper**.
Double-relief ground with 2 chamfers hollow ground for high-precision hard machining.
Recess angle α = 16°.
Tolerances:
· **Corner radius: R_1 = ±0.0025 mm.**
· **Neck ⌀: D_1 = 0 / -0.01 mm.**
Note:
At greater tool overhang lengths, use a reduced value for a_p!
Values for:
side milling: $a_p = 0.1 \times D \times a_p$ korr
copying: $a_p = 0.05 \times D \times a_p$ korr
To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)! e.g: vf = 18000 [rpm]× fz [mm/Z]× z
No. of teeth Z: 2
Helix angle: 30 degrees
Shank: DIN 6535 HA to h5
No. of teeth Z: 2
Flute length L_c: 2 mm
Corner radius R_1: 0.3 mm
Overhang length L_1 incl. recess: 12 mm
Recess ⌀ D_1: 1.91 mm
Overall length L: 55 mm

Technical description

Cutting edge ⌀ D_C	2 mm
Flute length L_c	2 mm
Shank	DIN 6535 HA to h5
Overall length L	55 mm
Feed f_z for copy milling in steel < 65 HRC	0.03 mm
Correction factor $a_{p\,corr}$	0.9
Corner radius R_1	0.3 mm
Feed f_z for side milling in steel < 65 HRC	0.03 mm
Helix angle	30 degrees
Shank ⌀ D_s	4 mm
Recess ⌀ D_1	1.91 mm
No. of teeth Z	2
Overhang length L_1 incl. recess	12 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal ⌀	0 / -0.005
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 copy milling
Through-coolant	no
Colour ring	red
Type of product	End mill