

**Garant**
**Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 1,5/0,15 mm**

**Order data**

Order number	206162 1,5/0,15
GTIN	4045197597700
Item class	11X

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

Special geometry, coating and carbide, specially for hard machining.

For copy milling with **angle  $\alpha$ : 1° 30'**. Double relief ground side clearance angle.

Tolerances:

- **Corner radius:  $R_1 = \pm 0.005$  mm.**
- **Angle  $\alpha = \pm 20'$ .**

**Note:**

Standard application values:

$f_z$  for  $a_p = 0.1 \times D$ .

No. of teeth Z: 2

Helix angle: 30 degrees

Shank: DIN 6535 HA to h6

No. of teeth Z: 2

Flute length  $L_c$ : 1.8 mm

Corner radius  $R_1$ : 0.15 mm

Overhang length  $L_1$  incl. recess: 3 mm

maximum shank recess dia.  $D_6$ : 2.7 mm

Recess  $\varnothing D_1$ : 1.45 mm

**Technical description**

$L_2$	27 mm
Overhang length $L_1$ incl. recess	3 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.005 mm
Recess $\varnothing D_1$	1.45 mm

No. of teeth Z	2
Cutting edge $\varnothing D_c$	1.5 mm
Corner radius $R_1$	0.15 mm
Feed $f_z$ for side milling in steel < 65 HRC	0.005 mm
Shank $\varnothing D_s$	3 mm
Flute length $L_c$	1.8 mm
Overall length L	75 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
maximum shank recess dia. $D_6$	2.7 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	e8
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	0.2×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	End mill