

Garant
Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 4/1,0 mm

Order data

Order number	206162 4/1,0
GTIN	4045197597762
Item class	11X

Description
Version:
GARANT Diabolo:

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

For copy milling with **angle α : 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 : 3 mm

Corner radius R_1 : 1 mm

Overhang length L_1 incl. recess: 16 mm

maximum shank recess dia. D_6 : 5.1 mm

Recess $\varnothing D_1$: 3.8 mm

Technical description

Overhang length L_1 incl. recess	16 mm
Recess $\varnothing D_1$	3.8 mm
Feed f_z for side milling in steel < 65 HRC	0.019 mm
Cutting edge $\varnothing D_c$	4 mm

No. of teeth Z	2
L_2	40 mm
Feed f_z for copy milling in steel < 65 HRC	0.019 mm
Corner radius R_1	1 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	3 mm
Overall length L	80 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
maximum shank recess dia. D_6	5.1 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

Services

Shank grinding Type HB	129100 HB
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