

Garant
Diabolo solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 12 mm

Order data

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|--------------|---------------|
| Order number | 206273 12 |
| GTIN | 4045197860828 |
| Item class | 11X |

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Tolerance: Corner radius $R_1 = \pm 0.01$ mm.

Special centre cutting edge geometry for traverse milling at very high feed rates.

Application:

For copy and traverse milling in hard machining **under HPC / HSC conditions**. Special milling strategies allow **very high metal removal rates**.

Note:

Successor product to No. 206276.

Tools can be reground.

No. of teeth Z: 4

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Dimension $a_{p\ max}$ transverse: 0.4 mm

Programming radius: 2 mm

Flute length L_c : 6.8 mm

Overhang length L_1 incl. recess: 30 mm

Recess $\varnothing D_1$: 11 mm

Technical description

| | |
|------------------------------------|--------|
| Overhang length L_1 incl. recess | 30 mm |
| Dimension $a_{p\ max}$ transverse | 0.4 mm |
| Recess $\varnothing D_1$ | 11 mm |
| Cutting edge $\varnothing D_c$ | 12 mm |

| | |
|---|----------------------------------|
| Programming radius | 2 mm |
| Feed f_z in steel < 60 HRC | 0.178 mm |
| Shank $\varnothing D_s$ | 12 mm |
| Flute length L_c | 6.8 mm |
| Overall length L | 93 mm |
| No. of teeth Z | 4 |
| Setting angle κ | 6 degrees |
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | H |
| Tolerance nominal \varnothing | h9 |
| Helix angle | 12 degrees |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting width a_e for milling operation | Full slot cutting depth 1xD |
| Shank | DIN 6535 HA to h5 |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | red |
| Type of product | End mill |

Services

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|---|-----------|
| Shank clamping flats for shrink-fit chucks, with retainer function Shank \varnothing tool 12 mm | SZ2025 12 |
| Shank grinding Type HB | 129100 HB |