

Garant
Diabolo solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 8 mm

Order data

Order number	206275 8
GTIN	4045197860880
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. 206278.

Tools can be reground.

No. of teeth Z: 4

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Dimension $a_{p\max}$ transverse: 0.25 mm

Programming radius: 1.5 mm

Flute length L_c : 4.8 mm

Overhang length L_1 incl. recess: 40 mm

Recess $\varnothing D_1$: 7 mm

Technical description

Flute length L_c	4.8 mm
Shank $\varnothing D_s$	8 mm
Overhang length L_1 incl. recess	40 mm
Feed f_z in steel < 60 HRC	0.086 mm

Recess $\varnothing D_1$	7 mm
No. of teeth Z	4
Cutting edge $\varnothing D_c$	8 mm
Programming radius	1.5 mm
Overall length L	100 mm
Dimension $a_{p \max}$ transverse	0.25 mm
Setting angle κ	5.5 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 $1 \times D$
Shank	DIN 6535 HA to h5
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End mill

Services

Shank grinding Type HB	129100 HB
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