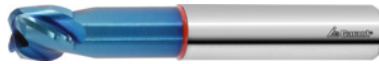


**Garant**
**Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 12/1,5 mm**

**Order data**

Order number	206322 12/1,5
GTIN	4045197598455
Item class	11X

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

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

Double relief ground side clearance angle.

Tolerance: Corner radius  $R_1 = \pm 0.005 \text{ mm}$ .

No. of teeth Z: 4

Helix angle: 30 degrees

Shank: DIN 6535 HA to h6

No. of teeth Z: 4

Flute length  $L_c$ : 12 mm

Corner radius  $R_1$ : 1.5 mm

Overhang length  $L_1$  incl. recess: 38 mm

Recess Ø  $D_1$ : 11 mm

Overall length L: 83 mm

**Technical description**

Cutting edge Ø $D_c$	12 mm
Corner radius $R_1$	1.5 mm
No. of teeth Z	4
Recess Ø $D_1$	11 mm
Feed $f_z$ for side milling in steel < 65 HRC	0.08 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.08 mm
Overhang length $L_1$ incl. recess	38 mm

Shank $\varnothing D_s$	12 mm
Flute length $L_c$	12 mm
Overall length $L$	83 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	e8
Spacing of the cutters	unequal spacing
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 recess Type FRST	209900 FRST
Shank clamping flats for shrink-fit chucks, with retainer function Shank $\varnothing$ tool 12 mm	SZ2025 12
Shank grinding Type HB	129100 HB