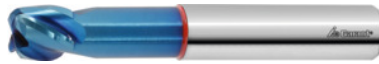


Garant
Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 8/1,0 mm

Order data

Order number	206322 8/1,0
GTIN	4045197598325
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 : 9 mm

Corner radius R_1 : 1 mm

Overhang length L_1 incl. recess: 27 mm

Recess Ø D_1 : 7.4 mm

Overall length L: 63 mm

Technical description

Recess Ø D_1	7.4 mm
Feed f_z for side milling in steel < 65 HRC	0.06 mm
Feed f_z for copy milling in steel < 65 HRC	0.06 mm
No. of teeth Z	4
Corner radius R_1	1 mm
Cutting edge Ø D_c	8 mm
Overhang length L_1 incl. recess	27 mm

Shank $\varnothing D_s$	8 mm
Flute length L_c	9 mm
Overall length L	63 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 grinding Type HB	129100 HB