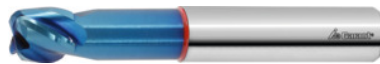


**Garant**
**Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 8/1,5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 206322 8/1,5  |
| GTIN         | 4045197598332 |
| 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  $R_1$ : 1.5 mm

Overhang length  $L_1$  incl. recess: 27 mm

Recess  $\varnothing D_1$ : 7.4 mm

Overall length L: 63 mm

**Technical description**

|                                               |         |
|-----------------------------------------------|---------|
| No. of teeth Z                                | 4       |
| Recess $\varnothing D_1$                      | 7.4 mm  |
| Overhang length $L_1$ incl. recess            | 27 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 |
| Cutting edge $\varnothing D_c$                | 8 mm    |
| Corner radius $R_1$                           | 1.5 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   |