

**Garant**
**Diabolo carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 3/1,0 mm**

**Order data**

Order number	206342 3/1,0
GTIN	4045197598684
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  $L_c$ : 4 mm

Corner radius  $R_1$ : 1 mm

Overhang length  $L_1$  incl. recess: 32 mm

Recess  $\varnothing D_1$ : 2.7 mm

Overall length L: 75 mm

**Technical description**

Feed $f_z$ for side milling in steel < 65 HRC	0.019 mm
Cutting edge $\varnothing D_c$	3 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.019 mm
No. of teeth Z	4
Corner radius $R_1$	1 mm
Recess $\varnothing D_1$	2.7 mm
Overhang length $L_1$ incl. recess	32 mm

Shank $\varnothing D_s$	3 mm
Flute length $L_c$	4 mm
Overall length $L$	75 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	0.05xD for copy milling
Cutting width $a_e$ for milling operation	0.2xD for side 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
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