

**Garant**
**Diabolo carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 8/0,25 mm**

**Order data**

Order number	206342 8/0,25
GTIN	4045197598813
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  $R_1$ : 0.25 mm

Overhang length  $L_1$  incl. recess: 54 mm

Recess  $\varnothing D_1$ : 7.4 mm

Overall length L: 100 mm

**Technical description**

No. of teeth Z	4
Cutting edge $\varnothing D_c$	8 mm
Feed $f_z$ for side milling in steel < 65 HRC	0.06 mm
Overhang length $L_1$ incl. recess	54 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.06 mm
Corner radius $R_1$	0.25 mm
Recess $\varnothing D_1$	7.4 mm

Shank $\varnothing D_s$	8 mm
Flute length $L_c$	9 mm
Overall length $L$	100 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	0.05×D for copy milling
Cutting width $a_e$ for milling operation	0.2×D 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
Shank grinding Type HB	129100 HB