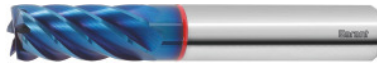


**Garant**
**GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 18mm**

**Order data**

Order number	203211 18
GTIN	4045197597465
Item class	11X

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

Special geometry, coating and carbide, specially for hard machining.  
Dimensions similar to DIN 6527.

**Application:**

**For profile milling as finishing.**

(Plunge cutting only to shallow depths).

**Technical description**

No. of teeth Z	8
Cutting edge Ø D <sub>c</sub>	18 mm
Feed f <sub>z</sub> for side milling in steel < 65 HRC	0.03 mm
Shank Ø D <sub>s</sub>	18 mm
Overall length L	92 mm
Flute length L <sub>c</sub>	36 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Helix angle	50 degrees
Corner chamfer angle	90 degrees

Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 1400 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 50 HRC	suitable	170 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	145 m/min	H
Steel < 65 HRC	suitable	100 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Services

Shank grinding Type HB	129100 HB
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