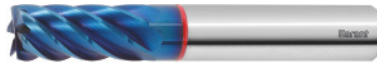


Garant
GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 4mm

Order data

Order number	203211 4
GTIN	4045197597380
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	6
Cutting edge Ø D _c	4 mm
Feed f _z for side milling in steel < 65 HRC	0.016 mm
Shank Ø D _s	6 mm
Overall length L	57 mm
Flute length L _c	13 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 ²	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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