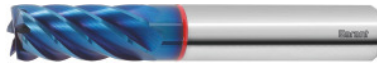


Garant
GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 8mm

Order data

Order number	203211 8
GTIN	4045197597410
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

Feed f_z for side milling in steel < 65 HRC	0.02 mm
No. of teeth Z	6
Cutting edge $\varnothing D_c$	8 mm
Shank $\varnothing D_s$	8 mm
Overall length L	63 mm
Flute length L_c	19 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	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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