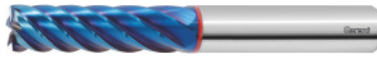


Garant
GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 25mm

Order data

| | |
|--------------|---------------|
| Order number | 203372 25 |
| GTIN | 4045197597595 |
| Item class | 11X |

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide, specially for hard machining.

Application:

For profile milling as finishing.

(Plunge cutting only to shallow depths).

Technical description

| | |
|--|------------------------|
| No. of teeth Z | 10 |
| Cutting edge Ø D _c | 25 mm |
| Feed f _z for side milling in steel < 65 HRC | 0.036 mm |
| Shank Ø D _s | 25 mm |
| Overall length L | 150 mm |
| Flute length L _c | 75 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 | Manufacturer's standard |
| 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 | 120 m/min | P |
| Steel < 50 HRC | suitable | 115 m/min | H |
| Steel < 55 HRC | suitable | 100 m/min | H |
| Steel < 60 HRC | suitable | 90 m/min | H |
| Steel < 65 HRC | suitable | 60 m/min | H |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |
| Air | suitable | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|