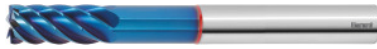


**Garant**
**GARANT Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 12mm**

**Order data**

Order number	203382 12
GTIN	4045197597632
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**

Feed $f_z$ for side milling in steel < 65 HRC	0.021 mm
No. of teeth Z	6
Recess $\varnothing D_1$	11.6 mm
Cutting edge $\varnothing D_c$	12 mm
Overhang length $L_1$ incl. recess	60 mm
Shank $\varnothing D_s$	12 mm
Overall length L	120 mm
Flute length $L_c$	30 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	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 <sup>2</sup>	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
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