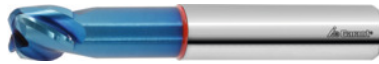


**Garant**
**Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1: 6/1,0 mm**

**Order data**

Order number	206322 6/1,0
GTIN	4045197598271
Item class	11X

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

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

Double relief ground side clearance angle.

Tolerance: Corner radius  $R_1 = \pm 0.005 \text{ mm}$ .

No. of teeth Z: 4

Helix angle:  $30^\circ$

Shank: DIN 6535 HA to h6

No. of teeth Z: 4

Flute length  $L_c$ : 7 mm

Corner radius  $R_1$ : 1 mm

Overhang length  $L_1$  incl. recess: 21 mm

Recess  $\varnothing D_1$ : 5.5 mm

Overall length L: 57 mm

**Technical description**

Recess $\varnothing D_1$	5.5 mm
Feed $f_z$ for side milling in steel < 65 HRC	0.048 mm
No. of teeth Z	4
Corner radius $R_1$	1 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.048 mm
Cutting edge $\varnothing D_c$	6 mm
Overhang length $L_1$ incl. recess	21 mm

Shank $\varnothing D_s$	6 mm
Flute length $L_c$	7 mm
Overall length $L$	57 mm
Shank	DIN 6535 HA to h6
Helix angle	30°
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	e8
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	0.2×D for side milling
Cutting width $a_e$ for milling operation	0.05×D for copy milling
Through-coolant	no
Machining strategy	HPC
Shank tolerance	h6
Colour ring	red
Type of product	Torus cutter

## User data

	Suitability	$V_c$	ISO code
Steel < 1400 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 50 HRC	suitable	190 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	150 m/min	H
Steel < 65 HRC	suitable	110 m/min	H

wet maximum	suitable only under restricted conditions
wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable
<b>Services</b>	
Shank grinding Type HB	129100 HB