

Garant
**GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1:
4/0,25mm**

Order data

| | |
|--------------|---------------|
| Order number | 206342 4/0,25 |
| GTIN | 4045197598707 |
| 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 **R₁ = ±0.005 mm.**

Technical description

| | |
|--------------------------------------------------------|-------------------|
| Corner radius R ₁ | 0.25 mm |
| Feed f _z for side milling in steel < 65 HRC | 0.019 mm |
| Overhang length L ₁ incl. recess | 36 mm |
| Cutting edge Ø D _c | 4 mm |
| Recess Ø D ₁ | 3.7 mm |
| Feed f _z for copy milling in steel < 65 HRC | 0.019 mm |
| No. of teeth Z | 4 |
| Shank Ø D _s | 4 mm |
| Flute length L _c | 5 mm |
| Overall length L | 75 mm |
| Shank | DIN 6535 HA to h6 |
| Helix angle | 30 degrees |

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|-------------------------------------------|----------------------------------|
| 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 | 0.05×D for copy milling |
| Cutting width a_e for milling operation | 0.2×D for side 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 ² | suitable | 160 m/min | P |
| Steel < 50 HRC | suitable | 150 m/min | H |
| Steel < 55 HRC | suitable | 135 m/min | H |
| Steel < 60 HRC | suitable | 120 m/min | H |
| Steel < 65 HRC | suitable | 90 m/min | H |
| wet maximum | suitable only under restricted conditions | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |
| Air | suitable | | |

