

Garant
**GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1:
6/0,25mm**

Order data

Order number	206342 6/0,25
GTIN	4045197598776
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

Cutting edge Ø D _c	6 mm
Recess Ø D ₁	5.5 mm
Feed f _z for side milling in steel < 65 HRC	0.048 mm
Feed f _z for copy milling in steel < 65 HRC	0.048 mm
No. of teeth Z	4
Overhang length L ₁ incl. recess	44 mm
Corner radius R ₁	0.25 mm
Shank Ø D _s	6 mm
Flute length L _c	7 mm
Overall length L	80 mm
Shank	DIN 6535 HA to h6
Helix angle	30 degrees

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		

Services

Shank grinding Type HB

129100 HB