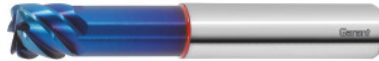


**Garant**
**GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1:  
12/1,5mm**

**Order data**

Order number	206372 12/1,5
GTIN	4045197599209
Item class	11X

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

Special geometry, coating and carbide for hard machining.

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

Dimensions according to factory standard and 50° helix.

Double relief ground side clearance angle.

Without dynamic twist pitch.

**Technical description**

Recess Ø $D_1$	11 mm
Overhang length $L_1$ incl. recess	38 mm
No. of teeth $Z$	6
Corner radius $R_1$	1.5 mm
Cutting edge Ø $D_c$	12 mm
Feed $f_z$ for copy milling in steel < 65 HRC	0.08 mm
Shank Ø $D_s$	12 mm
Flute length $L_c$	12 mm
Overall length $L$	83 mm
Shank	DIN 6535 HA to h6
Helix angle	50 degrees

Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	e8
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	0.05×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 <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		

## Services

Shank grinding Type HB

129100 HB