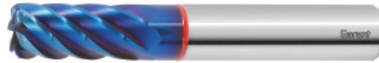


**Garant**
**GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1:  
12/1,5mm**

**Order data**

Order number	206422 12/1,5
GTIN	4045197599346
Item class	11X

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

Special geometry, coating and carbide for hard machining.

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

Tolerance: Corner radius  $RS_1 = \pm 0.005 \text{ mm}$ .

**Application:**

**For peripheral milling** as a **finishing operation** (plunge milling only to shallow depths).

**Technical description**

Feed $f_z$ for side milling in steel < 65 HRC	0.023 mm
No. of teeth Z	6
Corner radius $R_1$	1.5 mm
Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Flute length $L_c$	28 mm
Overall length L	83 mm
Shank	DIN 6535 HA to h6
Helix angle	45 degrees
Series	Diabolo
Coating	TiAlN

Tool material	Solid carbide
Standard	DIN 6527
Type	H
Tolerance nominal $\varnothing$	e8
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal and oblique
Cutting width $a_e$ for milling operation	0.05×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	170 m/min	P
Steel < 50 HRC	suitable	170 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	145 m/min	H
Steel < 65 HRC	suitable	100 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
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