

Garant
**GARANT Diabolo solid carbide torus cutter HPC, TiAlN, Ø e8 DC / R1:
16/1,0mm**

Order data

| | |
|--------------|---------------|
| Order number | 206422 16/1,0 |
| GTIN | 4045197599353 |
| 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

| | |
|---|-------------------|
| Corner radius R_1 | 1 mm |
| Feed f_z for side milling in steel < 65 HRC | 0.025 mm |
| No. of teeth Z | 8 |
| Cutting edge $\varnothing D_c$ | 16 mm |
| Shank $\varnothing D_s$ | 16 mm |
| Flute length L_c | 36 mm |
| Overall length L | 92 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 ² | 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 |
|------------------------|-----------|

