

**Garant**
**GARANT Diabolo solid carbide slot drill HPC, TiAlN, Ø e8 DC: 12mm**

**Order data**

Order number	201639 12
GTIN	4045197597335
Item class	11X

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

Special geometry, coating and carbide specially for hard machining.

New generation of high performance milling cutters in the **HPC machining range**.

From size 2 with neck recess (dimensions  $L_1$  and  $\varnothing D_1$ ).

**Technical description**

Cutting edge $\varnothing D_c$	12 mm
Recess $\varnothing D_1$	11.8 mm
Overhang length $L_1$ incl. recess	38 mm
Corner chamfer width at 45°	0.13 mm
Feed $f_z$ for slot milling in steel < 65 HRC	0.02 mm
Feed $f_z$ for side milling in steel < 65 HRC	0.024 mm
No. of teeth Z	2
Shank $\varnothing D_s$	12 mm
Overall length L	83 mm
Flute length $L_c$	26 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal $\varnothing$	e8

Helix angle	30 degrees
Corner chamfer angle	45 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Cutting width $a_e$ for milling operation	0.05×D for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 1400 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 50 HRC	suitable	110 m/min	H
Steel < 55 HRC	suitable	80 m/min	H
Steel < 60 HRC	suitable	60 m/min	H
Steel < 65 HRC	suitable	50 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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