

Garant**GARANT Diabolo solid carbide torus cutter HRC 62 HPC, TiSiN, Ø e8 DC / R1: 12/1,0mm****Order data**

Order number	206421 12/1,0
GTIN	4069515030700
Item class	11Z

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

Special geometry, coating and carbide for hard machining.

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

Specialist for steels up to 62 HRC. Reliable process and longer service life thanks to optimised cutter geometry and state-of-the-art high-performance coating.

Without dynamic helical pitch.

Technical description

Shank	DIN 6535 HA to h6
Helix angle	50 degrees
Corner radius R_1	1 mm
Recess $\varnothing D_1$	11 mm
Overhang length L_1 incl. recess	38 mm
Cutting edge $\varnothing D_c$	12 mm
No. of teeth Z	6
Flute length L_c	12 mm
Feed f_z for copy milling in steel < 65 HRC	0.08 mm
Shank $\varnothing D_s$	12 mm

Data sheet

Overall length L	83 mm
Feed f_z for side milling in steel < 60 HRC	0.05 mm
Feed f_z for copy milling in steel < 60 HRC	0.075 mm
Series	Diabolo
Coating	TiSiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	h7
Direction of infeed	horizontal, oblique and vertical
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 only under restricted conditions	170 m/min	P
Steel < 50 HRC	suitable only under restricted conditions	150 m/min	H
Steel < 55 HRC	suitable	130 m/min	H
Steel < 60 HRC	suitable	100 m/min	H
Steel < 65 HRC	suitable	80 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	65 m/min	H

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable
Suitable products	

<https://www.hoffmann-group.com/GB/en/hom/p/206421-12/1,0>