

**Garant****GARANT Diabolo solid carbide milling cutter HRC 62 HPC, TiSiN, Ø DC: 5mm****Order data**

Order number	203221 5
GTIN	4069515036597
Item class	11Z

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

Special geometry, coating and carbide specially for hard machining.

**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.

Dimensions similar to DIN 6527.

**Application:**

**For peripheral milling** as a **finishing operation**.

(plunge cutting only to shallow depths).

**Technical description**

Flute length $L_c$	15 mm
Helix angle	50 degrees
Overall length $L$	57 mm
No. of teeth $Z$	6
Shank $\varnothing D_s$	6 mm
Tolerance nominal $\varnothing$	h7
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	5 mm
Corner chamfer angle	90 degrees
Feed $f_z$ for side milling in steel < 60 HRC	0.03 mm

## Data sheet

Shank	DIN 6535 HA to h6
Series	Diabolo
Coating	TiSiN
Tool material	Solid carbide
Standard	DIN 6527
Type	H
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	$0.05 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	Indexable end mill

## User data

	Suitability	$V_c$	ISO code
Steel < 1400 N/mm <sup>2</sup>	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/203221-5>

