

Garant**GARANT Diabolo solid carbide milling cutter HRC 62 HPC, TiSiN, Ø DC: 8mm****Order data**

Order number	203221 8
GTIN	4069515036610
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

Feed f_z for side milling in steel < 60 HRC	0.04 mm
Shank	DIN 6535 HA to h6
Tolerance nominal Ø	h7
Helix angle	50 degrees
Cutting edge Ø D_c	8 mm
Shank Ø D_s	8 mm
Corner chamfer angle	90 degrees
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	6
Overall length L	63 mm

Data sheet

Flute length L_c	19 mm
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 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/203221-8>

