

## Garant

### GARANT Diabolo solid carbide end torus cutter HPC, TiAlN, Ø h9 DC: 3mm



#### Order data

Order number	206275 3
GTIN	4045197860842
Item class	11X

#### Description

##### Version:

##### GARANT Diabolo:

Special geometry, coating and carbide for hard machining.

Tolerance: Corner radius  $R_1 = \pm 0.01 \text{ mm}$ .

Special centre cutting edge geometry for traverse milling at very high feed rates.

##### Application:

**For copy and traverse milling** in hard machining **under HPC / HSC conditions**. Special milling strategies allow **very high metal removal rates**.

##### Note:

**Successor product to No. 206278.**

**Tools can be reground.**

#### Technical description

No. of teeth Z	2
Programming radius	0.3 mm
Cutting edge Ø D <sub>c</sub>	3 mm
Overall length L	75 mm
Shank Ø D <sub>s</sub>	6 mm
Feed f <sub>z</sub> in steel < 60 HRC	0.037 mm
Recess Ø D <sub>1</sub>	2.7 mm
Overhang length L <sub>1</sub> incl. recess	20 mm
Flute length L <sub>c</sub>	1.5 mm

Dimension $a_{p\ max}$ transverse	0.1 mm
Setting angle $\kappa$	8.5 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	h9
Helix angle	12 degrees
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Shank	DIN 6535 HA to h5
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End torus mill

## User data

	Suitability	$V_c$	ISO code
Steel < 1400 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 50 HRC	suitable	145 m/min	H
Steel < 55 HRC	suitable	130 m/min	H
Steel < 60 HRC	suitable	95 m/min	H
Steel < 65 HRC	suitable	70 m/min	H
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		

Air  
**Services**

suitable

Shank grinding Type HB

129100 HB