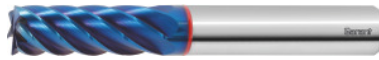


**Garant**
**Diabolo solid carbide milling cutter HPC, TiAlN, Ø e8 DC: 12mm**

**Order data**

Order number	203282 12
GTIN	4045197597519
Item class	11X

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

Special geometry, coating and carbide, specially for hard machining.

**Application:**

**For profile milling as finishing.**

(Plunge cutting only to shallow depths).

Tolerance nominal Ø: e8

No. of teeth Z: 6

Helix angle: 50°

Direction of infeed: horizontal and oblique

Shank: DIN 6535 HA to h6

No. of teeth Z: 6

Flute length  $L_c$ : 36 mm

Overall length L: 93 mm

Shank Ø  $D_s$ : 12 mm

Feed  $f_z$  for side milling in steel < 65 HRC: 0.025 mm

**Technical description**

No. of teeth Z	6
Feed $f_z$ for side milling in steel < 65 HRC	0.025 mm
Cutting edge Ø $D_c$	12 mm
Shank Ø $D_s$	12 mm
Overall length L	93 mm

Flute length $L_c$	36 mm
Direction of infeed	horizontal and oblique
Shank	DIN 6535 HA to h6
Tolerance nominal $\varnothing$	e8
Helix angle	50°
Corner chamfer angle	90°
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation	0.05×D for side milling
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	170 m/min	P
Steel < 50 HRC	suitable	170 m/min	H
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	145 m/min	H
Steel < 65 HRC	suitable	100 m/min	H
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		

## Services

Shank recess Type FRST	209900 FRST
Shank clamping flats for shrink-fit chucks, with retainer function Shank Ø tool 12 mm	SZ2025 12
Shank grinding Type HB	129100 HB