



## Solid carbide barrel milling cutter, conical form $\alpha/2 = 9^\circ$ PPC, TiAlN, $\varnothing$ f8 Dc / Rw: 12/500 mm



### Order data

Order number	207530 12/500
GTIN	4045197922700
Item class	11X

### Description

#### Version:

High-performance tool for **exceptionally efficient finish machining of free-form surfaces**. For outstanding surface qualities in a **very short machining time**. For use on modern 5-axis milling machines with CAD / CAM support.

The end face geometry is designed so that the chips, especially those formed by the end radius, are of optimum shape and have optimum evacuation characteristics. For this purpose the number of cutting edges is reduced to the number of effective end face cutting edges.

#### Recommendation:

As an oversize for finishing operations we recommend 0.05 to 0.2 mm.

#### Note:

$R_w$  represents the effective radius on the tool.

Cannot be reground!

For machining walls and overcoming obstructions.

No. of teeth Z: 4

Helix angle: 30 degrees

No. of teeth Z: 4

Flute length  $L_f$ : 22 mm

$R_w$  effective radius: 500 mm

Corner radius  $RS_1$ : 3 mm

Overall length  $L_{tot}$ : 90 mm

Shank  $\varnothing$ : 12 mm

### Technical description

Feed $f_z$ for side milling in steel $< 900$ N/mm <sup>2</sup>	0.07 mm
Correction factor $f_z$	1.25

No. of teeth Z	4
Shank Ø	12 mm
Feed $f_z$ for copy milling in steel < 900 N/mm <sup>2</sup>	0.09 mm
Flute length $L_s$	22 mm
Overall length $L_{tot}$	90 mm
$R_w$ effective radius	500 mm
Corner radius $RS_1$	3 mm
Helix angle	30 degrees
maximum cutting depth $a_{p,max}$ when side milling	22 mm
Coating	TiAlN
Tool material	Solid carbide
Norm	Manufacturer's standard
Type	N
Tolerance nominal Ø	f8
Direction of infeed	horizontal
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
Skaft	DIN 6535 HA to h6
Machining strategy	PPC
Colour ring	green

## Services

Shank grinding Type HB	129100 HB
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