



## Solid carbide barrel milling cutter, tangential form PPC, TiAlN, Ø f8 Dc / Rw: 12/40 mm



### Order data

Order number	207522 12/40
GTIN	4062406130954
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:

We recommend 0.05 to 0.2mm as an allowance for finishing operations.

#### Note:

$R_w$  represents the effective radius on the tool.

Cannot be reground!

No. of teeth Z: 6

Helix angle: 30 degrees

No. of teeth Z: 6

Flute length  $L_f$ : 18.5 mm

$R_w$  effective radius: 40 mm

Corner radius  $RS_1$ : 2 mm

Overall length  $L_{tot}$ : 90 mm

Shank Ø: 12 mm

### Technical description

Feed $f_z$ for side milling in steel < 60 HRC	0.035 mm
Corner radius $RS_1$	2 mm

Cutter $\varnothing D_c$	12 mm
Helix angle	30 degrees
Correction factor $f_z$	1.25
Flute length $L_s$	18.5 mm
Shank $\varnothing$	12 mm
$R_w$ effective radius	40 mm
No. of teeth Z	6
Overall length $L_{tot}$	90 mm
Feed $f_z$ for copy milling in steel < 60 HRC	0.04 mm
Minimum tool overhang	18.5 mm
Coating	TiAlN
Tool material	Solid carbide
Norm	Manufacturer's standard
Type	N
Tolerance nominal $\varnothing$	f8
Direction of infeed	horizontal
Cutting width $a_e$ for milling operation	0.05×D for copy milling
Cutting width $a_e$ for milling operation	0.05×D for side milling
Skaft	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	PPC
Colour ring	red

## Services

Shank grinding Type HB

129100 HB