

Garant

Solid carbide barrel milling cutter, conical form $\alpha/2 = 18^\circ$ PPC, TiAlN, \varnothing f8 DC / R2: 6/100mm



Order data

Order number	207541 6/100
GTIN	4062406286811
Item class	11X

Description

Version:

Innovative coating concept for **machining hardened materials**.

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_2 represents the effective radius on the tool.

Cannot be reground!

For machining walls and overcoming obstructions.

Successor product to No. 207527.

Technical description

Flute length L_c	8.5 mm
Shank $\varnothing D_s$	6 mm
Overall length L	60 mm
Helix angle	30 degrees
Corner radius R_1	0.5 mm

Feed f_z for side milling in steel < 60 HRC	0.02 mm
No. of teeth Z	4
Effective radius R_2	100 mm
Feed f_z for copy milling in steel < 60 HRC	0.025 mm
Cutting edge $\varnothing D_c$	6 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal \varnothing	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
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	PPC
Colour ring	red
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Steel < 1400 N/mm ²	suitable	200 m/min	P
Steel < 55 HRC	suitable	170 m/min	H
Steel < 60 HRC	suitable	150 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	110 m/min	H
wet maximum	suitable only under restricted conditions		
dry	suitable		

Air

suitable