

Garant

Solid carbide barrel milling cutter, short conical form $\alpha/2 = 72^\circ$ PPC, TiAlN, \emptyset f8 DC / R2: 12/100mm



Order data

Order number	207551 12/100
GTIN	4062406286859
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.

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 surface machining and avoidance of interferences.

Successor product to No. 207556.

Technical description

Feed f_z for side milling in steel < 60 HRC	0.035 mm
Corner radius R_1	2 mm
Cutting edge $\emptyset D_c$	12 mm
Helix angle	30 degrees
Flute length L_c	2.5 mm
No. of teeth Z	5
Feed f_z for copy milling in steel < 60 HRC	0.04 mm

Overall length L	100 mm
Shank $\varnothing D_s$	12 mm
Effective radius R_2	100 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
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Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	PPC
Colour ring	yellow
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		

