

Garant

Solid carbide barrel milling cutter, short conical form $\alpha/2 = 81^\circ$ PPC, TiAlN, \varnothing f8 DC / R2: 12/100mm



Order data

Order number	207553 12/100
GTIN	4062406286866
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. 207559.

Technical description

Helix angle	30 degrees
No. of teeth Z	5
Feed f_z for side milling in steel < 60 HRC	0.035 mm
Shank $\varnothing D_s$	12 mm
Effective radius R_2	100 mm
Cutting edge $\varnothing D_c$	12 mm
Overall length L	100 mm

Flute length L_c	1.7 mm
Feed f_z for copy milling in steel < 60 HRC	0.04 mm
Corner radius R_1	4 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 copy milling
Cutting width a_e for milling operation	0.05×D for side 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	110 m/min	H
wet maximum	suitable		
dry	suitable		
Air	suitable		