

Garant

Solid carbide barrel milling cutter, short conical form $\alpha/2 = 81^\circ$ PPC, TiAlN, \emptyset 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.

No. of teeth Z: 5

Helix angle: 30°

No. of teeth Z: 5

Flute length L_c : 1.7 mm

Effective radius R_2 : 100 mm

Corner radius R_1 : 4 mm

Overall length L: 100 mm

Shank $\emptyset D_s$: 12 mm

Technical description

Helix angle	30°
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