

Garant

Solid carbide barrel milling cutter, conical form $\alpha/2 = 18^\circ$ PPC, TiAlN, \varnothing f8 DC / R2: 16/1000mm



Order data

Order number	207537 16/1000
GTIN	4045197922731
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:

As an oversize for finishing operations we recommend 0.05 to 0.2 mm.

Note:

R_2 represents the effective radius on the tool.

Cannot be reground!

For machining walls and overcoming obstructions.

Technical description

Feed f_z for side milling in INOX > 900 N/mm ²	0.065 mm
No. of teeth Z	6
Feed f_z for copy milling in stainless steel > 900 N/mm ²	0.08 mm
Flute length L_c	16 mm
Overall length L	90 mm
Shank $\varnothing D_s$	16 mm
Effective radius R_2	1000 mm

Corner radius R_1	4 mm
Helix angle	30 degrees
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
Machining strategy	PPC
Colour ring	blue
Type of product	Ball-nosed slot drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
INOX < 900 N/mm ²	suitable	150 m/min	M
INOX > 900 N/mm ²	suitable	140 m/min	M
Ti > 850 N/mm ²	suitable	70 m/min	S
Inconel	suitable	60 m/min	S
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		

Air

suitable only under
restricted conditions

Services

Shank grinding Type HB

129100 HB