

Garant

Solid carbide barrel milling cutter, conical form $\alpha/2 = 9^\circ$ PPC, TiAlN, \varnothing f8 DC / R2: 12/500mm


Order data

Order number	207535 12/500
GTIN	4045197922717
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:

R₂ represents the effective radius on the tool.

Cannot be reground!

For machining walls and overcoming obstructions.

Technical description

Shank \varnothing D _s	12 mm
Feed f _z for side milling in INOX > 900 N/mm ²	0.052 mm
No. of teeth Z	6
Overall length L	90 mm
Flute length L _c	22 mm
Feed f _z for copy milling in stainless steel > 900 N/mm ²	0.064 mm
Effective radius R ₂	500 mm

Corner radius R_1	3 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	$0.05 \times D$ for copy milling
Cutting width a_e for milling operation	$0.05 \times D$ for side 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

Services

suitable only under
restricted conditions

Shank grinding Type HB

129100 HB