

Garant

Solid carbide barrel milling cutter, tangential form PPC, TiAlN, Ø f8 DC / R2: 6/100mm



Order data

Order number	207525 6/100
GTIN	4045197922632
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!

Technical description

No. of teeth Z	4
Shank Ø D_s	6 mm
Flute length L_c	20.5 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.04 mm
Overall length L	62 mm
Feed f_z for copy milling in steel < 900 N/mm ²	0.05 mm
Effective radius R_2	100 mm

Corner radius R ₁	1 mm
Helix angle	30 degrees
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal Ø	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
Through-coolant	no
Machining strategy	PPC
Colour ring	green
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
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	suitable	130 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	90 m/min	H
INOX < 900 N/mm ²	suitable	130 m/min	M

INOX > 900 N/mm ²	suitable	120 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	60 m/min	S
GG(G)	suitable	300 m/min	K
Uni	suitable		
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