

**Garant**
**Solid carbide barrel milling cutter, straight form PPC, DLC, Ø f8 DC / R2:  
12/70mm**

**Order data**

Order number	207514 12/70
GTIN	4045197989000
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.

**Recommendation:**

We recommend 0.05 to 0.2mm as an allowance for finishing operations.

**Note:**

R<sub>2</sub> represents the effective radius on the tool.  
Cannot be reground!

**Technical description**

Helix angle	30 degrees
No. of teeth Z	5
Effective radius R <sub>2</sub>	70 mm
Overall length L	83 mm
Cutting edge Ø D <sub>c</sub>	12 mm
Corner radius R <sub>1</sub>	1 mm
Flute length L <sub>c</sub>	23 mm
Feed f <sub>z</sub> for copy milling in short-chipping aluminium	0.09 mm
Overhang length L <sub>1</sub> incl. recess	36 mm

Recess $\varnothing D_1$	10 mm
Shank $\varnothing D_s$	12 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.07 mm
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal $\varnothing$	f8
Spacing of the cutters	unequal spacing
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	yellow
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	330 m/min	N
Aluminium (short chipping)	suitable	300 m/min	N
Alu > 10% Si	suitable	230 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

## Services

Shank grinding Type HB

129100 HB