Garant

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

Order data

Order number	207517 6/100
GTIN	4045197989017
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:
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!

Technical description

No. of teeth Z	4
Corner radius R_1	1 mm
Flute length L_c	20.5 mm
Cutting edge ∅ D_C	6 mm
Effective radius R_2	100 mm
Feed f_z for side milling in short-chipping aluminium	0.04 mm
Helix angle	30 degrees

Feed f_z for copy milling in short-chipping aluminium	0.05 mm
Overall length L	62 mm
Shank ⌀ D_s	6 mm
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal ⌀	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	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