

**Garant**

**Solid carbide barrel milling cutter, short conical form  $\alpha/2 = 63^\circ$  PPC, DLC,  $\varnothing$  f8  
DC / R2: 12/220mm**


**Order data**

|              |               |
|--------------|---------------|
| Order number | 207542 12/220 |
| GTIN         | 4045197989109 |
| 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:**

$R_2$  represents the effective radius on the tool.

Cannot be reground!

For surface machining and avoidance of interference contours.

**Technical description**

|   |            |
|---|------------|
| Overall length L  | 120 mm     |
| Flute length $L_c$                                      | 3.5 mm     |
| Feed $f_z$ for copy milling in short-chipping aluminium | 0.09 mm    |
| Cutting edge $\varnothing D_c$                          | 12 mm      |
| Corner radius $R_1$                                     | 2 mm       |
| Helix angle   | 30 degrees |
| Effective radius $R_2$                                  | 220 mm     |
| No. of teeth Z  | 5          |
| 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                      |
| Direction of infeed                                     | horizontal              |
| Cutting width $a_e$ for milling operation               | 0.05×D for side milling |
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| 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 |
|------------------------|-----------|

