

## Garant

**Solid carbide barrel milling cutter, short conical form  $\alpha/2 = 81^\circ$  PPC, DLC,  $\varnothing$  f8  
DC / R2: 8/180mm**



### Order data

Order number	207548 8/180
GTIN	4045197989130
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

Flute length $L_c$	1.4 mm
Helix angle	30 degrees
Cutting edge $\varnothing D_c$	8 mm
Shank $\varnothing D_s$	8 mm
Effective radius $R_2$	180 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.055 mm
No. of teeth $Z$	3
Corner radius $R_1$	3 mm
Feed $f_z$ for copy milling in short-chipping aluminium	0.065 mm

Overall length L	80 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
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