

Garant

**Solid carbide barrel milling cutter, short conical form $\alpha/2 = 81^\circ$ PPC, DLC, \varnothing f8
DC / R2: 12/220mm**



Order data

Order number	207548 12/220
GTIN	4045197989147
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

No. of teeth Z	5
Helix angle	30 degrees
Effective radius R_2	220 mm
Cutting edge $\varnothing D_c$	12 mm
Corner radius R_1	4 mm
Feed f_z for copy milling in short-chipping aluminium	0.09 mm
Overall length L	120 mm
Shank $\varnothing D_s$	12 mm
Feed f_z for side milling in short-chipping aluminium	0.07 mm

Flute length L_c	1.4 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
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
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