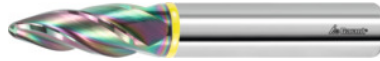


**Garant****Solid carbide barrel milling cutter, tangential form PPC, DLC, Ø f8 DC / R2:  
10/90 mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 207517 10/90  |
| GTIN         | 4045197989024 |
| 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!

No. of teeth Z: 4

Helix angle: 30 degrees

No. of teeth Z: 4

Flute length  $L_c$ : 24.5 mm

Effective radius  $R_2$ : 90 mm

Corner radius  $R_1$ : 2 mm

Overall length L: 80 mm

Shank Ø  $D_s$ : 10 mm

**Technical description**

|                |       |
|----------------|-------|
| No. of teeth Z | 4     |
| Shank Ø $D_s$  | 10 mm |

|                                                         |                         |
|---------------------------------------------------------|-------------------------|
| Feed $f_z$ for side milling in short-chipping aluminium | 0.06 mm                 |
| Cutting edge $\varnothing D_c$                          | 10 mm                   |
| Flute length $L_c$                                      | 24.5 mm                 |
| Helix angle                                             | 30 degrees              |
| Feed $f_z$ for copy milling in short-chipping aluminium | 0.08 mm                 |
| Effective radius $R_2$                                  | 90 mm                   |
| Overall length $L$                                      | 80 mm                   |
| Corner radius $R_1$                                     | 2 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 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                                         | End mill                |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|