

## Garant

**Solid carbide barrel milling cutter, conical form  $\alpha/2=18^\circ$  PPC, DLC,  $\varnothing$  f8 DC / R2: 6/250 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 207531 6/250  |
| GTIN         | 4045197989055 |
| 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:

For machining walls and overcoming obstructions.

$R_2$  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  $L_c$ : 8 mm

Effective radius  $R_2$ : 250 mm

Corner radius  $R_1$ : 0.5 mm

Overall length L: 60 mm

Shank  $\varnothing$   $D_s$ : 6 mm

### Technical description

|             |            |
|-------------|------------|
| Helix angle | 30 degrees |
|-------------|------------|

|   |                         |
|---|-------------------------|
| Flute length $L_c$                                      | 8 mm                    |
| Effective radius $R_2$                                  | 250 mm                  |
| Cutting edge $\varnothing D_c$                          | 6 mm                    |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.04 mm                 |
| Overall length $L$                                      | 60 mm                   |
| Feed $f_z$ for copy milling in short-chipping aluminium | 0.05 mm                 |
| Corner radius $R_1$                                     | 0.5 mm                  |
| Shank $\varnothing D_s$                                 | 6 mm                    |
| No. of teeth $Z$  | 4                       |
| 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   | End mill                |

## Services

Shank grinding Type HB

129100 HB