

## Garant

### Solid carbide barrel milling cutter, tangential form PPC, TiAlN, Ø f8 DC / R2: 6/100 mm



#### Order data

Order number	207525 6/100
GTIN	4045197922632
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:

As an oversize for finishing operations we recommend 0.05 to 0.2 mm.

##### 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  $L_c$ : 20.5 mm

Effective radius  $R_2$ : 100 mm

Corner radius  $R_1$ : 1 mm

Overall length L: 62 mm

Shank  $\varnothing D_s$ : 6 mm

#### Technical description

No. of teeth Z	4
Shank $\varnothing D_s$	6 mm

Flute length $L_c$	20.5 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.04 mm
Overall length $L$	62 mm
Feed $f_z$ for copy milling in steel $< 900 \text{ N/mm}^2$	0.05 mm
Effective radius $R_2$	100 mm
Corner radius $R_1$	1 mm
Helix angle	30 degrees
Coating	TiAlN
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	$0.05 \times D$ for side milling
Cutting width $a_e$ for milling operation	$0.05 \times D$ for copy milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	PPC
Colour ring	green
Type of product	End mill

## Services

Shank grinding Type HB	129100 HB
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