

## Garant

**Solid carbide barrel milling cutter, conical form  $\alpha/2 = 9^\circ$  PPC, TiAlN,  $\varnothing$  f8 DC / R2: 12/500 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 207530 12/500 |
| GTIN         | 4045197922700 |
| 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!

For machining walls and overcoming obstructions.

No. of teeth Z: 4

Helix angle: 30 degrees

No. of teeth Z: 4

Flute length  $L_c$ : 22 mm

Effective radius  $R_2$ : 500 mm

Corner radius  $R_1$ : 3 mm

Overall length L: 90 mm

Shank  $\varnothing$   $D_s$ : 12 mm

### Technical description

|   |         |
|---|---------|
| Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$ | 0.07 mm |
|---|---------|

|  |                         |
|--|-------------------------|
| No. of teeth Z   | 4                       |
| Shank $\varnothing D_s$                                      | 12 mm                   |
| Feed $f_z$ for copy milling in steel < 900 N/mm <sup>2</sup> | 0.09 mm                 |
| Flute length $L_c$   | 22 mm                   |
| Overall length L   | 90 mm                   |
| Effective radius $R_2$                                       | 500 mm                  |
| Corner radius $R_1$  | 3 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×D for side milling |
| Cutting width $a_e$ for milling operation                    | 0.05×D for copy milling |
| Shank  | DIN 6535 HA to h6       |
| Machining strategy   | PPC                     |
| Colour ring  | green                   |
| Type of product  | End mill                |

## Services

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