

## Garant

### GARANT Master Steel PickPocket solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 3,8mm



#### Order data

Order number	202402 3,8
GTIN	4062406088057
Item class	11X

#### Description

##### Version:

For **roughing and finishing**

With corner radii similar to torus cutters.

Up to 1×D into solid material **at very high feed rates** with smooth cutting action.

Corner radii matched to DIN specifications for **drive keyways**.

##### Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

#### Technical description

No. of teeth Z	3
Shank	DIN 6535 HB to h6
Shank Ø D <sub>s</sub>	6 mm
Overall length L	54 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.04 mm
Helix angle	38 degrees
Flute length L <sub>c</sub>	5 mm
Cutting edge Ø D <sub>c</sub>	3.8 mm
Tolerance nominal Ø	f8
Direction of infeed	horizontal, oblique and vertical

Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.03 mm
Corner rounding $r_v$	0.12 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.4 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	260 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	240 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	190 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
GG(G)	suitable	250 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
dry	suitable
Air	suitable