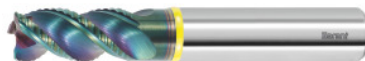


Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC, DLC, Ø e8 DC: 10mm****Order data**

| | |
|--------------|---------------|
| Order number | 205255 10 |
| GTIN | 4062406122379 |
| Item class | 11X |

Description**Version:**

For roughing.

Special profile for machining non-ferrous metals.

Improved chip evacuation due to central through-coolant.

Advantage:

Optimised flute form, eccentric relief ground, generous chip spaces.

Up to $2 \times D$ into solid material at very high feed rates and smooth cutting action.

Ramping capability up to 45° .

Very high feed rates when plunging vertically, thanks to **special plunging geometry**.

Note:

For **HB** shanks use order **No. 205256**.

Technical description

| | |
|---|----------------------------------|
| Helix angle | 35 degrees |
| Overall length L | 72 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.12 mm |
| Shank $\varnothing D_s$ | 10 mm |
| Flute length L_c | 22 mm |
| No. of teeth Z | 3 |
| Direction of infeed | horizontal, oblique and vertical |

| | |
|---|--------------------------------------|
| Overhang length L_1 incl. recess | 30 mm |
| Balance quality with shank | G 2.5 with HA |
| Shank | DIN 6535 HA to h6 |
| Feed f_z for side milling in short-chipping aluminium | 0.14 mm |
| Cutting edge $\varnothing D_c$ | 10 mm |
| Recess $\varnothing D_1$ | 9.5 mm |
| Tolerance nominal \varnothing | e8 |
| Corner rounding r_v | 0.32 mm |
| Series | Master Alu |
| Coating | DLC |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Milling profile | WR |
| 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 | Full slot cutting depth $1 \times D$ |
| Through-coolant | yes |
| Machining strategy | HPC |
| Colour ring | yellow |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|-----------|----------|
| Aluminium | Suitable | 450 m/min | N |
| Aluminium (short chipping) | suitable | 400 m/min | N |
| Alu > 10% Si | suitable | 380 m/min | N |

| | | | |
|-------------|---|-----------|---|
| PA 66 | suitable only under restricted conditions | 120 m/min | N |
| PEEK | suitable only under restricted conditions | 100 m/min | N |
| Cu | Suitable | 160 m/min | N |
| CuZn | Suitable | 200 m/min | N |
| wet maximum | suitable | | |
| Air | suitable | | |

Services

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