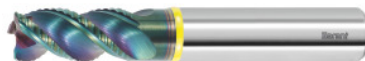


**Garant**
**GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC, DLC, Ø e8 DC: 18mm**

**Order data**

Order number	205255 18
GTIN	4062406122416
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  $45^\circ$ .

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

**Note:**

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

**Technical description**

Feed $f_z$ for side milling in short-chipping aluminium	0.25 mm
Balance quality with shank	G 2.5 with HA
Tolerance nominal Ø	e8
Overall length L	92 mm
Flute length $L_c$	31 mm
Recess Ø $D_1$	17 mm
Direction of infeed	horizontal, oblique and vertical

No. of teeth Z	4
Helix angle	35 degrees
Overhang length $L_1$ incl. recess	42 mm
Shank	DIN 6535 HA to h6
Feed $f_z$ for slot milling in short-chipping aluminium	0.22 mm
Cutting edge $\varnothing D_c$	18 mm
Shank $\varnothing D_s$	18 mm
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