

**Garant**
**GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 3,8mm**

**Order data**

Order number	202002 3,8
GTIN	4062406127565
Item class	11X

**Description**
**Version:**

For roughing and finishing.

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

Very high feed rates when plunging vertically.

Ramping capability up to  $45^\circ$ .

**Advantage:**

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

**Technical description**

Balance quality with shank	G 2.5 with HA
No. of teeth Z	3
Feed $f_z$ for slot milling in short-chipping aluminium	0.04 mm
Shank	DIN 6535 HA to h6
Helix angle	42 degrees
Tolerance nominal $\varnothing$	e8
Cutting edge $\varnothing D_c$	3.8 mm
Shank $\varnothing D_s$	6 mm
Flute length $L_c$	8 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.05 mm

Overall length L	57 mm
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
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	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	250 m/min	N
Aluminium (short chipping)	suitable	200 m/min	N
Alu > 10% Si	Suitable	180 m/min	N
PMMA acrylic	Suitable	180 m/min	N
PE-HD	Suitable	130 m/min	N
PA 66	Suitable	150 m/min	N
PEEK	Suitable	130 m/min	N
PF 31	Suitable	110 m/min	N

Honeycomb sandwich	suitable only under restricted conditions	180 m/min	N
Cu	Suitable	120 m/min	N
CuZn	Suitable	150 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		