ᚏᚏ Hoffmann Group

Garant

GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 18mm

Order data

Order number	202002 18
GTIN	4062406125851
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°.
Advantage:
Optimised flute form, eccentric relief ground, generous chip spaces.

Technical description

Overhang length L_1 incl. recess	42 mm
Cutting edge Ø D_c	18 mm
Recess Ø D_1	17.8 mm
Balance quality with shank	G 2.5 with HA
Overall length L	92 mm
Shank Ø D_s	18 mm
Flute length L_c	31 mm
No. of teeth Z	3
Feed f_z for side milling in short-chipping aluminium	0.2 mm
Direction of infeed	horizontal, oblique and vertical

Feed f_z for slot milling in short-chipping aluminium	0.16 mm
Shank	DIN 6535 HA to h6
Tolerance nominal ∅	e8
Helix angle	42 degrees
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×D
Cutting width a_e for milling operation	Full slot cutting depth 1×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		

Services

Shank grinding Type HB	129100 HB