

## Garant

### GARANT Master Alu PickPocket solid carbide roughing end mill with through-coolant HPC, DLC, Ø e8 DC: 6mm



#### Order data

Order number	202006 6
GTIN	4062406126117
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  $45^\circ$ .

Improved chip evacuation due to central through-coolant. Due to the patented geometry also suitable for boring.

With the latest generation of DLC coating  $sp^2$ .

##### Advantage:

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

#### Technical description

Balance quality with shank	G 2.5 with HA
Tolerance nominal Ø	e8
Feed $f_z$ for slot milling in short-chipping aluminium	0.06 mm
Cutting edge Ø $D_c$	6 mm
Shank	DIN 6535 HA to h6
Flute length $L_c$	13 mm
Helix angle	42 degrees
Direction of infeed	horizontal, oblique and vertical

No. of teeth Z	3
Overall length L	57 mm
Overhang length L <sub>1</sub> incl. recess	19 mm
Shank Ø D <sub>s</sub>	6 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.08 mm
Recess Ø D <sub>1</sub>	5.8 mm
Corner rounding r <sub>v</sub>	0.2 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Through-coolant	yes
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium	Suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N

PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	Suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	Suitable	150 m/min	N
PEEK GF30	Suitable	130 m/min	N
PTFE CF25	Suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
<del>Air</del>	<del>suitable</del>		

### Services

Shank grinding Type HB

129100 HB