

**Garant**
**GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 9mm**

**Order data**

Order number	202012 9
GTIN	4062406126278
Item class	11X

**Description**
**Version:**

For roughing and finishing.

Up to 2×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.**

**Note:**

A minimum oversize of 0.1×D must be maintained for subsequent finishing operations.

**Technical description**

No. of teeth Z	3
Overall length L	80 mm
Shank Ø D <sub>s</sub>	10 mm
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.08 mm
Recess Ø D <sub>1</sub>	8.8 mm
Direction of infeed	horizontal, oblique and vertical
Tolerance nominal Ø	e8
Shank	DIN 6535 HA to h6
Overhang length L <sub>1</sub> incl. recess	38 mm

Flute length $L_c$	22 mm
Helix angle	42 degrees
Cutting edge $\varnothing D_c$	9 mm
Balance quality with shank	G 2.5 with HA
Feed $f_z$ for slot milling in short-chipping aluminium	0.06 mm
Corner chamfer angle	90 degrees
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
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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