

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

Order data

Order number	202014 18
GTIN	4062406126421
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° .

With the latest generation of DLC coating sp^2 .

Advantage:

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

Note:

A minimum oversize of $0.1 \times D$ must be maintained for subsequent finishing operations.

Technical description

Shank	DIN 6535 HA to h6
Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	67 mm
Feed f_z for slot milling in short-chipping aluminium	0.14 mm
Recess Ø D_1	17.8 mm
Shank Ø D_s	18 mm
Overall length L	117 mm

Flute length L_c	31 mm
Feed f_z for side milling in short-chipping aluminium	0.16 mm
Cutting edge $\varnothing D_c$	18 mm
No. of teeth Z	3
Balance quality with shank	G 2.5 with HA
Helix angle	42 degrees
Corner rounding r_v	0.32 mm
Series	Master Alu
Coating	DLC
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 $1 \times D$
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	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		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

Services

Shank grinding Type HB

129100 HB