

Garant
GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC, DLC, Ø e8 DC: 5mm

Order data

| | |
|--------------|---------------|
| Order number | 205256 5 |
| GTIN | 4062406276935 |
| Item class | 11X |

Description
Version:

For roughing.

Special profile for machining non-ferrous metals.

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

Advantage:

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

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

Ramping capability up to 45° .

Very high feed rates when plunging vertically, thanks to **special plunging geometry**.

Technical description

| | |
|---|----------------------------------|
| No. of teeth Z | 3 |
| Feed f_z for side milling in short-chipping aluminium | 0.08 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Flute length L_c | 9 mm |
| Balance quality with shank | G 2.5 with HB |
| Helix angle | 35 degrees |
| Tolerance nominal \varnothing | e8 |
| Overall length L | 57 mm |

| | |
|---|--------------------------------------|
| Cutting edge $\varnothing D_c$ | 5 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.06 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Shank | DIN 6535 HB to h6 |
| Corner rounding r_v | 0.2 mm |
| Series | Master Alu |
| Coating | DLC |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Milling profile | WR |
| 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 | yes |
| Machining strategy | HPC |
| Colour ring | yellow |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|-----------|----------|
| Aluminium | Suitable | 450 m/min | N |
| Aluminium (short chipping) | suitable | 400 m/min | N |
| Alu > 10% Si | suitable | 380 m/min | N |
| Cu | Suitable | 160 m/min | N |
| CuZn | Suitable | 200 m/min | N |
| wet maximum | suitable | | |
| Air | suitable | | |

Services

Shank grinding Type HB

129100 HB