

Garant
GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 4Mmm

Order data

Order number	202002 4M
GTIN	4062406380861
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	17 mm
Shank	DIN 6535 HA to h6
No. of teeth Z	3
Tolerance nominal \varnothing	e8
Feed f_z for side milling in short-chipping aluminium	0.06 mm
Direction of infeed	horizontal, oblique and vertical
Shank $\varnothing D_s$	6 mm
Corner chamfer angle	90 degrees
Overall length L	57 mm
Balance quality with shank	G 2.5 with HA

Flute length L_c	11 mm
Recess $\varnothing D_1$	3.7 mm
Cutting edge $\varnothing D_c$	4 mm
Feed f_z for slot milling in short-chipping aluminium	0.05 mm
Helix angle	42 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 $1 \times D$
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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 Services	suitable		
Shank grinding Type HB		129100 HB	