

## Garant

### GARANT Master Alu PickPocket solid carbide roughing end mill with through-coolant HPC, DLC, Ø e6 DC: 10mm



#### Order data

Order number	202019 10
GTIN	4062406381103
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°.

Improved chip evacuation due to central through-coolant.

Very long overhang for safe machining of deep cavities.

With the latest generation of DLC coating sp<sup>2</sup>.

##### 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
Tolerance nominal Ø	e8
Balance quality with shank	G 2.5 with HA
Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.07 mm
Shank	DIN 6535 HA to h6
Shank Ø D <sub>s</sub>	10 mm
Direction of infeed	horizontal, oblique and vertical

Overall length L	100 mm
Overhang length L <sub>1</sub> incl. recess	58 mm
Helix angle	42 degrees
Flute length L <sub>c</sub>	16 mm
Recess Ø D <sub>1</sub>	9.2 mm
Cutting edge Ø D <sub>c</sub>	10 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.05 mm
Corner rounding r <sub>v</sub>	0.2 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 <sub>e</sub> for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium	Suitable	380 m/min	N
Aluminium (short chipping)	Suitable	300 m/min	N
Alu > 10% Si	suitable	270 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
PVDF GF20	Suitable	160 m/min	N
POM GF25	Suitable	150 m/min	N
PA 66 GF30	Suitable	140 m/min	N
PEEK GF30	suitable	120 m/min	N
PTFE CF25	suitable	150 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	220 m/min	N
Cu	Suitable	140 m/min	N
CuZn	Suitable	160 m/min	N
wet maximum	suitable		
Air	Suitable		