

Garant
GARANT Master Alu PickPocket solid carbide roughing end mill HPC, DLC, Ø e6 DC: 4mm

Order data

Order number	202017 4
GTIN	4062406381004
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°.

Very long overhang for safe machining of deep cavities.

With the latest generation of DLC coating sp².

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

Helix angle	42 degrees
Shank Ø D _s	6 mm
Feed f _z for slot milling in short-chipping aluminium	0.03 mm
Balance quality with shank	G 2.5 with HA
Overall length L	80 mm
Overhang length L ₁ incl. recess	24 mm
Feed f _z for side milling in short-chipping aluminium	0.04 mm
Tolerance nominal Ø	e8

No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.1 mm
Recess $\varnothing D_1$	3.7 mm
Shank	DIN 6535 HA to h6
Flute length L_c	6.5 mm
Cutting edge $\varnothing D_c$	4 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	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	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		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		

Services

Shank grinding Type HB

129100 HB