

Garant

GARANT Master Alu PickPocket solid carbide roughing end mill HPC, DLC, Ø e6 DC: 12mm



Order data

| | |
|--------------|---------------|
| Order number | 202017 12 |
| GTIN | 4062406381059 |
| 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° .

Very long overhang for safe machining of deep cavities.

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

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|---|----------------------------------|
| Direction of infeed | horizontal, oblique and vertical |
| Corner rounding r_v | 0.2 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.06 mm |
| Recess $\varnothing D_1$ | 11 mm |
| Shank $\varnothing D_s$ | 12 mm |
| Balance quality with shank | G 2.5 with HA |
| Feed f_z for side milling in short-chipping aluminium | 0.08 mm |
| Flute length L_c | 19 mm |

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|---|---------------------------------|
| Cutting edge $\varnothing D_c$ | 12 mm |
| Shank | DIN 6535 HA to h6 |
| Tolerance nominal \varnothing | e8 |
| Helix angle | 42 degrees |
| No. of teeth Z | 3 |
| Overhang length L_1 incl. recess | 73 mm |
| Overall length L | 120 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 |

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|--------------------|---|-----------|---|
| 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 | | |