

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 8mm



Order data

Order number	205267 8
GTIN	4062406377403
Item class	11X

Description

Version:

For roughing.

Special profile for machining non-ferrous metals. Significant reduction in the chip volume due to targeted chip fragmentation using the **special cutter geometry**.

Improved chip evacuation due to central through-coolant.

Note:

For **HB shanks** use order **no. 205268**.

h_{max} : The values stated in the table are maximum values.

ae_{max} is $0.2 \times D$ for TPC machining.

Technical description

Shank	DIN 6535 HA to h6
Direction of infeed	horizontal, oblique and vertical
Overall length L	68 mm
Tolerance nominal Ø	e8
Recess Ø D_1	7.5 mm
Feed f_z for slot milling in short-chipping aluminium	0.1 mm
Feed f_z for side milling in short-chipping aluminium	0.12 mm
Overhang length L_1 incl. recess	30 mm
No. of teeth Z	3

Helix angle	35 degrees
Flute length L_c	24 mm
Cutting edge $\varnothing D_c$	8 mm
Corner rounding r_v	0.2 mm
Balance quality with shank	G 2.5 with HA
Shank $\varnothing D_s$	8 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Milling profile	WR
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.2×D
Through-coolant	yes
Machining strategy	HPC
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

PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
Air	suitable		