

Garant
GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 12mm

Order data

Order number	205267 12
GTIN	4062406381226
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

Flute length L_c	36 mm
Recess $\varnothing D_1$	11 mm
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 2.5 with HA
No. of teeth Z	3
Feed f_z for slot milling in short-chipping aluminium	0.15 mm
Corner rounding r_v	0.32 mm
Shank $\varnothing D_s$	12 mm
Overall length L	93 mm

Tolerance nominal \varnothing	e8
Feed f_z for side milling in short-chipping aluminium	0.18 mm
Overhang length L_1 incl. recess	46 mm
Cutting edge $\varnothing D_c$	12 mm
Helix angle	35 degrees
Shank	DIN 6535 HA to h6
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		