

Garant
GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 20mm

Order data

Order number	205267 20
GTIN	4062406381240
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

Helix angle	35 degrees
No. of teeth Z	4
Feed f_z for slot milling in short-chipping aluminium	0.25 mm
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 2.5 with HA
Tolerance nominal Ø	e8
Cutting edge Ø D_c	20 mm
Overall length L	126 mm
Corner rounding r_v	0.5 mm

Recess $\varnothing D_1$	19 mm
Flute length L_c	60 mm
Overhang length L_1 incl. recess	74 mm
Feed f_z for side milling in short-chipping aluminium	0.28 mm
Shank $\varnothing D_s$	20 mm
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		