

GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 10mm



Order data

Order number	205275 10
GTIN	4062406381332
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.**

Problem-solver for **TPC machining.** Ideal for automated production as the risk of chip accumulations in the machine is largely prevented.

Note

For HB shanks use order no. 205277.

HB shanks are available at the same price as HA.

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

 ae_{max} is $0.12 \times D$ for TPC machining.

Technical description

No. of teeth Z	3	
Corner rounding r _v	0.32 mm	
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.065 mm	
Tolerance nominal Ø	e8	
Balance quality with shank	G 2.5 with HA	
Shank	DIN 6535 HA to h6	
Shank Ø D₅	10 mm	

Recess Ø D ₁	9.5 mm		
Flute length L _c	51 mm		
Overhang length L₁ incl. recess	60 mm		
Overall length L	104 mm		
Cutting edge \emptyset D _C	10 mm		
Direction of infeed	horizontal, oblique and vertical		
Helix angle	35 degrees		
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	0.12×D		
Through-coolant	no		
Machining strategy	HPC		
Colour ring	yellow		
Type of product	End / face mill		

User data

	Suitability	V _c	ISO code
Aluminium	Suitable	360 m/min	N
Aluminium (short chipping)	suitable	320 m/min	N
Alu > 10% Si	Suitable	300 m/min	N
PA 66	suitable only under restricted conditions	100 m/min	N
PEEK	suitable only under restricted conditions	80 m/min	N

Cu	Suitable	130 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		