Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 8mm

Order data

Order number	205274 8
GTIN	4062406381264
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. 205276**.
HB shanks are available at the same price as HA.
h_{max}: The values stated in the table are maximum values.
ae_{max} is $0.15 \times D$ for TPC machining.

Technical description

Balance quality with shank	G 2.5 with HA
Shank	DIN 6535 HA to h6
Shank Ø D_s	8 mm
Overhang length L_1 incl. recess	40 mm
No. of teeth Z	3
Overall length L	80 mm
Corner rounding r_v	0.2 mm
Helix angle	35 degrees

Tolerance nominal Ø	e8
Recess Ø D_1	7.5 mm
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.057 mm
Flute length L_c	33 mm
Direction of infeed	horizontal, oblique and vertical
Cutting edge Ø D_c	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	0.15×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	400 m/min	N
Aluminium (short chipping)	Suitable	360 m/min	N
Alu > 10% Si	suitable	340 m/min	N
PA 66	suitable only under restricted conditions	110 m/min	N
PEEK	suitable only under restricted conditions	90 m/min	N

Cu	Suitable	140 m/min	N
CuZn	Suitable	180 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable		