

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 12mm



Order data

Order number	205274 12
GTIN	4062406381288
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
Overall length L	110 mm
Tolerance nominal Ø	e8
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.086 mm
Helix angle	35 degrees
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	49 mm

Overhang length L_1 incl. recess	60 mm
No. of teeth Z	3
Corner rounding r_v	0.32 mm
Cutting edge $\varnothing D_c$	12 mm
Shank $\varnothing D_s$	12 mm
Shank	DIN 6535 HA to h6
Recess $\varnothing D_1$	11 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	$0.15 \times D$
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		