

## Garant

### GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 6mm



#### Order data

Order number	205276 6
GTIN	4062406581350
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:

Please use tools with HB drive flats for particularly demanding roughing machining tasks. Can be ordered in the Hoffmann Group's e-shop.

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

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

#### Technical description

Helix angle	35 degrees
Recess Ø $D_1$	5.7 mm
Average chip thickness $h_{max}$ for TPC milling in short-chipping aluminium	0.039 mm
Shank Ø $D_s$	6 mm
Flute length $L_c$	25 mm
Balance quality with shank	G 2.5 with HB
Corner rounding $r_v$	0.2 mm

Overall length L	70 mm
Tolerance nominal $\varnothing$	e8
Overhang length L <sub>1</sub> incl. recess	30 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
No. of teeth Z	3
Cutting edge $\varnothing D_c$	6 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 <sub>e</sub> 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 <sub>c</sub>	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		