

## Garant

### GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 20mm



#### Order data

Order number	205276 20
GTIN	4062406581404
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

Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Overall length L	150 mm
Balance quality with shank	G 2.5 with HB
Tolerance nominal Ø	e8
Helix angle	35 degrees
Flute length $L_c$	82 mm
Corner rounding $r_v$	0.5 mm

Recess $\varnothing D_1$	19 mm
Overhang length $L_1$ incl. recess	100 mm
Shank $\varnothing D_s$	20 mm
No. of teeth Z	4
Cutting edge $\varnothing D_c$	20 mm
Average chip thickness $h_{max}$ for TPC milling in short-chipping aluminium	0.13 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	$0.12 \times D$
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		