

Garant

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



Order data

Order number	205276 12
GTIN	4062406581381
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

Corner rounding r_v	0.32 mm
Overhang length L_1 incl. recess	60 mm
Helix angle	35 degrees
Recess $\varnothing D_1$	11 mm
No. of teeth Z	3
Cutting edge $\varnothing D_c$	12 mm
Direction of infeed	horizontal, oblique and vertical

Average chip thickness h_{\max} for TPC milling in short-chipping aluminium	0.078 mm
Flute length L_c	49 mm
Tolerance nominal \varnothing	e8
Balance quality with shank	G 2.5 with HB
Overall length L	110 mm
Shank	DIN 6535 HB to h6
Shank $\varnothing D_s$	12 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		