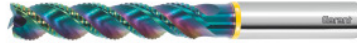


## Garant

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



#### Order data

Order number	205277 6
GTIN	4062406585815
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  $0.1 \times D$  for TPC machining.

#### Technical description

No. of teeth Z	3
Cutting edge Ø $D_c$	6 mm
Shank Ø $D_s$	6 mm
Flute length $L_c$	31 mm
Overhang length $L_1$ incl. recess	36 mm
Helix angle	35 degrees
Balance quality with shank	G 2.5 with HB
Shank	DIN 6535 HB to h6

Overall length L	75 mm
Tolerance nominal $\varnothing$	e8
Recess $\varnothing D_1$	5.7 mm
Corner rounding $r_v$	0.2 mm
Average chip thickness $h_{max}$ for TPC milling in short-chipping aluminium	0.036 mm
Direction of infeed	horizontal, oblique and vertical
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	$0.1 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	360 m/min	N
Aluminium (short chipping)	suitable	320 m/min	N
Alu > 10% Si	Suitable	300 m/min	N
PA 66	suitable only under restricted conditions	100 m/min	N
PEEK	suitable only under restricted conditions	80 m/min	N

Cu	Suitable	130 m/min	N
CuZn	Suitable	160 m/min	N
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable		