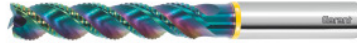


Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill HPC, DLC, Ø e8 DC: 8mm



Order data

Order number	205277 8
GTIN	4062406585822
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

Shank	DIN 6535 HB to h6
Tolerance nominal Ø	e8
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.048 mm
No. of teeth Z	3
Balance quality with shank	G 2.5 with HB
Shank Ø D_s	8 mm
Direction of infeed	horizontal, oblique and vertical

Corner rounding r_v	0.2 mm
Helix angle	35 degrees
Recess $\varnothing D_1$	7.5 mm
Cutting edge $\varnothing D_c$	8 mm
Overhang length L_1 incl. recess	48 mm
Flute length L_c	41 mm
Overall length L	90 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	$0.1 \times D$
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		