

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 12mm



Order data

Order number	205268 12
GTIN	4067263243489
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**.

Improved chip evacuation due to central through-coolant. Due to the patented geometry also suitable for boring.

Technical description

Feed f_z for side milling in short-chipping aluminium	0.18 mm
Shank	DIN 6535 HB to h6
Overall length L	93 mm
Tolerance nominal \varnothing	e8
Flute length L_c	36 mm
Shank $\varnothing D_s$	12 mm
Cutting edge $\varnothing D_c$	12 mm
Balance quality with shank	G 2.5 with HB
Overhang length L_1 incl. recess	46 mm
Feed f_z for slot milling in short-chipping aluminium	0.15 mm
Helix angle	35 degrees

Recess $\varnothing D_1$	11 mm
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.32 mm
No. of teeth Z	3
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	$0.5 \times D$ for side milling
Cutting width a_e for milling operation	$0.3 \times D$ for side milling
Through-coolant	yes
Machining strategy	TPC
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Aluminium	suitable	450 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	380 m/min	N
PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 m/min	N
Cu	suitable	160 m/min	N

CuZn	suitable	200 m/min	N
wet maximum	suitable		
Air	suitable		