

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 20mm



Order data

Order number	205268 20
GTIN	4067263243502
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

No. of teeth Z	4
Recess Ø D ₁	19 mm
Shank	DIN 6535 HB to h6
Feed f _z for slot milling in short-chipping aluminium	0.25 mm
Flute length L _c	60 mm
Cutting edge Ø D _c	20 mm
Direction of infeed	horizontal, oblique and vertical
Shank Ø D _s	20 mm
Tolerance nominal Ø	e8
Corner rounding r _v	0.5 mm
Feed f _z for side milling in short-chipping aluminium	0.28 mm

Helix angle	35 degrees
Overhang length L_1 incl. recess	74 mm
Balance quality with shank	G 2.5 with HB
Overall length L	126 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	0.5×D for side milling
Cutting width a_e for milling operation	0.3×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		