

Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill HPC, DLC, Ø e8 DC: 4mm****Order data**

Order number	205251 4
GTIN	4067263130352
Item class	11X

Description**Version:**

For roughing. Special profile for machining non-ferrous metals.

Advantage:

Optimised flute form, eccentric relief ground, generous chip spaces.

Up to $2 \times D$ into solid material at very high feed rates and smooth cutting action.

Ramping capability up to 45° .

Very high feed rates when plunging vertically, thanks to **special plunging geometry**.

Technical description

Shank $\varnothing D_s$	6 mm
Balance quality with shank	G 2.5 with HB
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.1 mm
Tolerance nominal \varnothing	e8
Cutting edge $\varnothing D_c$	4 mm
Overall length L	57 mm
Feed f_z for slot milling in short-chipping aluminium	0.04 mm
Flute length L_c	8 mm
Feed f_z for side milling in short-chipping aluminium	0.06 mm

Data sheet

Shank	DIN 6535 HB to h6
Helix angle	35 degrees
No. of teeth Z	3
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	WR
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
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		

Data sheet

wet minimum	suitable only under restricted conditions
dry	suitable only under restricted conditions
Air Services	suitable
Shank grinding Type HB	129100 HB