

Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill HPC, DLC, Ø e8 DC: 6mm****Order data**

Order number	205266 6
GTIN	4067263130451
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	DIN 6535 HA to h6
Helix angle	35 degrees
Tolerance nominal Ø	e8
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.2 mm
Overall length L	62 mm
Overhang length L_1 incl. recess	24 mm
Feed f_z for slot milling in short-chipping aluminium	0.08 mm
Balance quality with shank	G 2.5 with HA
Feed f_z for side milling in short-chipping aluminium	0.1 mm

Data sheet

Recess $\varnothing D_1$	5.5 mm
Cutting edge $\varnothing D_c$	6 mm
No. of teeth Z	3
Shank $\varnothing D_s$	6 mm
Flute length L_c	18 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Works standard
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

Data sheet

CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air Services	suitable		
Shank grinding Type HB			129100 HB