

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill HPC, DLC, Ø e8 DC: 18mm



Order data

Order number	205251 18
GTIN	4067263130437
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

Overhang length L_1 incl. recess	42 mm
Shank	DIN 6535 HB to h6
Flute length L_c	31 mm
Tolerance nominal \varnothing	e8
Feed f_z for side milling in short-chipping aluminium	0.25 mm
Balance quality with shank	G 2.5 with HB
No. of teeth Z	4
Feed f_z for slot milling in short-chipping aluminium	0.22 mm
Helix angle	35 degrees
Cutting edge $\varnothing D_c$	18 mm

Recess $\varnothing D_1$	17 mm
Shank $\varnothing D_s$	18 mm
Direction of infeed	horizontal, oblique and vertical
Corner rounding r_v	0.32 mm
Overall length L	92 mm
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		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		