

Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill HPC / TPC, DLC, Ø h7 DC: 20mm****Order data**

Order number	205282 20
GTIN	4069515036559
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**.

As a result of the 5 teeth, even higher feed rates are possible. The end face is supported by an additional **stabilising chamfer**, which leads to **smoother operation during helical plunging**.

Note:

For **HB shanks**: use order **No. 205283**.

HB shanks are available at the same price as HA.

Cutting data for TPC machining in the ToolScout.

Technical description

Balance quality with shank	G 2.5 with HA
No. of teeth Z	5
Helix angle	35 degrees
Tolerance nominal Ø	h7
Overall length L	125 mm
Flute length L _c	64 mm
Corner chamfer angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
Recess Ø D ₁	19 mm

Data sheet

Shank Ø D _s	20 mm
Corner chamfer width at 45°	0.5 mm
Shank	DIN 6535 HA to h6
Cutting edge Ø D _c	20 mm
Overhang length L ₁ incl. recess	74 mm
Feed f _z for side milling in short-chipping aluminium	0.25 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	0.4×D for side milling
Cutting width a _e for milling operation	0.25×D
Through-coolant	no
Machining strategy	HPC
Machining strategy	TPC
Colour ring	yellow
Type of product	Indexable end mill

User data

	Suitability	V _c	ISO code
Aluminium	suitable	500 m/min	N
Aluminium (short chipping)	suitable	480 m/min	N
Alu > 10% Si	suitable	450 m/min	N
PA 66	suitable only under restricted conditions	120 m/min	N

Data sheet

PEEK	suitable only under restricted conditions	100 m/min	N
Cu	suitable only under restricted conditions	160 m/min	N
CuZn	suitable only under restricted conditions	200 m/min	N
wet maximum	suitable		
Air	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/205282-20>