

Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill HPC / TPC, DLC, Ø h7 DC: 12mm****Order data**

Order number	205283 12
GTIN	4069515040013
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:

Cutting data for TPC machining in the ToolScout.

Technical description

Helix angle	35 degrees
Recess Ø D ₁	11 mm
Cutting edge Ø D _c	12 mm
Direction of infeed	horizontal, oblique and vertical
Feed f _z for side milling in short-chipping aluminium	0.15 mm
Tolerance nominal Ø	h7
No. of teeth Z	5
Shank	DIN 6535 HB to h6
Flute length L _c	39 mm
Overhang length L ₁ incl. recess	46 mm

Data sheet

Corner chamfer angle	45 degrees
Shank Ø D _s	12 mm
Overall length L	93 mm
Balance quality with shank	G 2.5 with HB
Corner chamfer width at 45°	0.32 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	0.25×D
Cutting width a _e for milling operation	0.4×D for side milling
Through-coolant	no
Machining strategy	TPC
Machining strategy	HPC
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
PEEK	suitable only under restricted conditions	100 m/min	N

Data sheet

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		