

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

Order number	205283 20
GTIN	4069515040037
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

Corner chamfer angle	45 degrees
Feed f_z for side milling in short-chipping aluminium	0.25 mm
Shank Ø D_s	20 mm
Shank	DIN 6535 HB to h6
Overhang length L_1 incl. recess	74 mm
Recess Ø D_1	19 mm
Corner chamfer width at 45°	0.5 mm
Overall length L	125 mm
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 2.5 with HB

Data sheet

Cutting edge $\varnothing D_c$	20 mm
No. of teeth Z	5
Tolerance nominal $\varnothing$	h7
Flute length L_c	64 mm
Helix angle	35 degrees
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	$0.25 \times D$
Cutting width a_e for milling operation	$0.4 \times D$ 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		