

Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill HPC / TPC, DLC, Ø h7 DC: 6mm****Order data**

Order number	205283 6
GTIN	4069515039987
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

Cutting edge Ø D _c	6 mm
Balance quality with shank	G 2.5 with HB
No. of teeth Z	5
Tolerance nominal Ø	h7
Corner chamfer width at 45°	0.2 mm
Corner chamfer angle	45 degrees
Direction of infeed	horizontal, oblique and vertical
Flute length L _c	20 mm
Shank	DIN 6535 HB to h6
Feed f _z for side milling in short-chipping aluminium	0.08 mm

Data sheet

Overall length L	65 mm
Recess Ø D ₁	5.5 mm
Shank Ø D _s	6 mm
Helix angle	35 degrees
Overhang length L ₁ incl. recess	24 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		