

Garant

GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 12mm



Order data

| | |
|--------------|---------------|
| Order number | 202012 12 |
| GTIN | 4062406126292 |
| Item class | 11X |

Description

Version:

For roughing and finishing.

Up to 2×D into solid material at very high feed rates and smooth cutting action.

Very high feed rates when plunging vertically.

Ramping capability up to 45°.

Advantage:

Optimised flute form, eccentric relief ground, generous chip spaces.

Note:

A minimum oversize of 0.1×D must be maintained for subsequent finishing operations.

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 42°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length L_c : 26 mm

Overhang length L_1 incl. recess: 46 mm

Recess Ø D_1 : 11.8 mm

Overall length L: 93 mm

Shank Ø D_s : 12 mm

Technical description

| | |
|----------------------------|---------------|
| Balance quality with shank | G 2.5 with HA |
|----------------------------|---------------|

| | |
|---|----------------------------------|
| Helix angle | 42 ° |
| Tolerance nominal Ø | e8 |
| Shank | DIN 6535 HA to h6 |
| Flute length L_c | 26 mm |
| Overhang length L_1 incl. recess | 46 mm |
| Feed f_z for side milling in short-chipping aluminium | 0.1 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Shank Ø D_s | 12 mm |
| Recess Ø D_1 | 11.8 mm |
| Overall length L | 93 mm |
| Cutting edge Ø D_c | 12 mm |
| Feed f_z for slot milling in short-chipping aluminium | 0.08 mm |
| No. of teeth Z | 3 |
| Corner chamfer angle | 90 ° |
| Series | Master Alu |
| Coating | uncoated |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | W |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | Full slot cutting depth 1×D |
| Cutting width a_e for milling operation | Full slot cutting depth 1×D |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | yellow |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|---|----------------------|-----------------|
| Aluminium | Suitable | 250 m/min | N |
| Aluminium (short chipping) | suitable | 200 m/min | N |
| Alu > 10% Si | suitable | 180 m/min | N |
| PMMA acrylic | Suitable | 180 m/min | N |
| PE-HD | Suitable | 130 m/min | N |
| PA 66 | Suitable | 150 m/min | N |
| PEEK | Suitable | 130 m/min | N |
| PF 31 | Suitable | 110 m/min | N |
| Honeycomb sandwich | suitable only under restricted conditions | 180 m/min | N |
| Cu | Suitable | 120 m/min | N |
| CuZn | Suitable | 150 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable only under restricted conditions | | |
| Air | suitable | | |

Services

Shank grinding Type HB

129100 HB