

**Garant**
**GARANT Master Alu solid carbide milling cutter HPC, uncoated, Ø DC: 5mm**

**Order data**

Order number	202470 5
GTIN	4062406245566
Item class	11X

**Description**
**Version:**
**Extra sharp cutting edges.**

Dimensions similar to DIN 6527.

Double relief ground side clearance angle.

For roughing and finishing. Up to 2xD into solid material at very high feed rates and smooth cutting action.

**Note:**
**Successor product to No. 202480.**

Tolerance nominal Ø: h6

No. of teeth Z: 4

Helix angle: 38 °

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 4

Flute length  $L_c$ : 15 mm

Overhang length  $L_1$  incl. recess: 20 mm

Recess Ø  $D_1$ : 4.7 mm

Overall length L: 57 mm

Shank Ø  $D_s$ : 6 mm

**Technical description**

Direction of infeed	horizontal, oblique and vertical
Flute length $L_c$	15 mm
Recess Ø $D_1$	4.7 mm

Overhang length $L_1$ incl. recess	20 mm
Shank	DIN 6535 HA to h6
Feed $f_z$ for side milling in short-chipping aluminium	0.08 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.06 mm
Cutting edge $\varnothing D_c$	5 mm
Shank $\varnothing D_s$	6 mm
Helix angle	38 °
Tolerance nominal $\varnothing$	h6
No. of teeth Z	4
Overall length L	57 mm
Corner chamfer angle	90 °
Series	Master Alu
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 6527
Type	W
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
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 only under restricted conditions		

## Services

Shank grinding Type HB

129100 HB