

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 10mm



Order data

| | |
|--------------|---------------|
| Order number | 205267 10 |
| GTIN | 4062406381219 |
| 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**.

Improved chip evacuation due to central through-coolant.

Note:

For **HB shanks** use order **no. 205268**.

h_{max} : The values stated in the table are maximum values.

ae_{max} is $0.15 \times D$ for TPC machining.

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 35 °

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 : 30 mm

Overhang length L_1 incl. recess: 38 mm

Recess Ø D_1 : 9.5 mm

Overall length L: 80 mm

Shank Ø D_s : 10 mm

Technical description

| | |
|----------------|--------|
| Recess Ø D_1 | 9.5 mm |
|----------------|--------|

| | |
|---|----------------------------------|
| No. of teeth Z | 3 |
| Corner rounding r_v | 0.32 mm |
| Tolerance nominal \varnothing | e8 |
| Overall length L | 80 mm |
| Flute length L_c | 30 mm |
| Cutting edge $\varnothing D_c$ | 10 mm |
| Shank | DIN 6535 HA to h6 |
| Helix angle | 35 ° |
| Feed f_z for slot milling in short-chipping aluminium | 0.12 mm |
| Feed f_z for side milling in short-chipping aluminium | 0.14 mm |
| Shank $\varnothing D_s$ | 10 mm |
| Overhang length L_1 incl. recess | 38 mm |
| Balance quality with shank | G 2.5 with HA |
| Direction of infeed | horizontal, oblique and vertical |
| Series | Master Alu |
| Coating | DLC |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Milling profile | WR |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | 0.5×D for side milling |
| Cutting width a_e for milling operation | Full slot cutting depth 1×D |
| Cutting width a_e for milling operation | 0.15×D |
| Through-coolant | yes |
| Machining strategy | HPC |
| Machining strategy | HPC |
| Colour ring | yellow |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|---|----------------------|-----------------|
| Aluminium | Suitable | 450 m/min | N |
| Aluminium (short chipping) | suitable | 400 m/min | N |
| Alu > 10% Si | suitable | 380 m/min | N |
| PA 66 | suitable only under restricted conditions | 120 m/min | N |
| PEEK | suitable only under restricted conditions | 100 m/min | N |
| Cu | Suitable | 160 m/min | N |
| CuZn | Suitable | 200 m/min | N |
| wet maximum | suitable | | |
| Air | suitable | | |