

Garant
GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e6 DC: 6mm

Order data

Order number	202008 6
GTIN	4062406380724
Item class	11X

Description
Version:

For roughing and finishing.

Up to $2 \times D$ 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.

Tolerance nominal \varnothing : 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 : 18 mm

Overhang length L_1 incl. recess: 24 mm

Recess $\varnothing D_1$: 5.8 mm

Overall length L: 62 mm

Shank $\varnothing D_s$: 6 mm

Technical description

Cutting edge $\varnothing D_c$	6 mm
Feed f_z for slot milling in short-chipping aluminium	0.04 mm

Overhang length L_1 incl. recess	24 mm
Overall length L	62 mm
Balance quality with shank	G 2.5 with HA
Flute length L_c	18 mm
No. of teeth Z	3
Recess $\varnothing D_1$	5.8 mm
Feed f_z for side milling in short-chipping aluminium	0.06 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	42 °
Corner chamfer angle	90 °
Shank	DIN 6535 HA to h6
Shank $\varnothing D_s$	6 mm
Tolerance nominal \varnothing	e8
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 $1 \times D$
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		

Services

Shank grinding Type HB

129100 HB