

## Garant

### GARANT Master Steel PickPocket solid carbide roughing end mill HPC, TiAlN, Ø f8 DC: 7,7mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 202404 7,7    |
| GTIN         | 4045197779281 |
| Item class   | 11X           |

#### Description

##### Version:

For **roughing and finishing**

With corner radii similar to torus cutters.

Up to 1×D into solid material **at very high feed rates** with smooth cutting action.

##### Advantage:

Optimised flute form, eccentric relief ground, wide chip space.

#### Technical description

|   |                                  |
|---|----------------------------------|
| Shank   | DIN 6535 HB to h6                |
| Recess Ø D <sub>1</sub>   | 7.5 mm                           |
| Tolerance nominal Ø   | f8                               |
| No. of teeth Z  | 3                                |
| Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup> | 0.06 mm                          |
| Flute length L <sub>c</sub>   | 19 mm                            |
| Cutting edge Ø D <sub>c</sub>   | 7.7 mm                           |
| Overall length L  | 63 mm                            |
| Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup> | 0.05 mm                          |
| Shank Ø D <sub>s</sub>  | 8 mm                             |
| Direction of infeed   | horizontal, oblique and vertical |

|   |                             |
|---|-----------------------------|
| Overhang length $L_1$ incl. recess        | 25 mm                       |
| Helix angle                               | 38 degrees                  |
| Corner rounding $r_v$                     | 0.39 mm                     |
| Series                                    | Master Steel                |
| Coating                                   | TiAlN                       |
| Tool material                             | Solid carbide               |
| Standard                                  | DIN 6527                    |
| Type                                      | N                           |
| Helix angle characteristic                | unequal spacing             |
| Spacing of the cutters                    | unequal spacing             |
| Cutting width $a_e$ for milling operation | 0.4×D for side milling      |
| Cutting width $a_e$ for milling operation | Full slot cutting depth 1×D |
| Through-coolant                           | no                          |
| Machining strategy                        | HPC                         |
| Colour ring                               | green                       |
| Type of product                           | End / face mill             |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 260 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 240 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 190 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 180 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 150 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 80 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 70 m/min  | M        |
| GG(G)                          | suitable                                  | 250 m/min | K        |
| Uni                            | suitable                                  |           |          |

|             |   |
|-------------|---|
| wet maximum | suitable                                  |
| wet minimum | suitable only under restricted conditions |
| dry         | suitable                                  |
| Air         | suitable                                  |