Hoffmann Group

Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 8mm

Order data

Order number	205275 8
GTIN	4062406381325
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.**
Problem-solver for **TPC machining.** Ideal for automated production as the risk of chip accumulations in the machine is largely prevented.
Note:
For **HB shanks** use order **no. 205277**.
HB shanks are available at the same price as HA.
h_{max}: The values stated in the table are maximum values.
ae_{max} is $0.12 \times D$ for TPC machining.

Technical description

Tolerance nominal Ø	e8
Helix angle	35 degrees
Flute length L_c	41 mm
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Recess Ø D_1	7.5 mm
Cutting edge Ø D_c	8 mm

Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.052 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	48 mm
Overall length L	90 mm
Balance quality with shank	G 2.5 with HA
Corner rounding r_v	0.2 mm
Shank Ø D_s	8 mm
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	0.12×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	360 m/min	N
Aluminium (short chipping)	suitable	320 m/min	N
Alu > 10% Si	Suitable	300 m/min	N
PA 66	suitable only under restricted conditions	100 m/min	N

PEEK	suitable only under restricted conditions	80 m/min	N
Cu	Suitable	130 m/min	N
CuZn	Suitable	160 m/min	N
wet maximum	Suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable		