

## Garant

### GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 10mm



#### Order data

Order number	205275 10
GTIN	4062406381332
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

No. of teeth Z	3
Corner rounding $r_v$	0.32 mm
Average chip thickness $h_{max}$ for TPC milling in short-chipping aluminium	0.065 mm
Tolerance nominal Ø	e8
Balance quality with shank	G 2.5 with HA
Shank	DIN 6535 HA to h6
Shank Ø $D_s$	10 mm

Recess $\varnothing D_1$	9.5 mm
Flute length $L_c$	51 mm
Overhang length $L_1$ incl. recess	60 mm
Overall length $L$	104 mm
Cutting edge $\varnothing D_c$	10 mm
Direction of infeed	horizontal, oblique and vertical
Helix angle	35 degrees
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	$0.12 \times D$
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	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		