Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, ⌀ e8 DC: 16mm

Order data

Order number	205275 16
GTIN	4062406381356
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 × D for TPC machining.

Technical description

Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.104 mm
Flute length L_c	81 mm
Cutting edge ⌀ D_C	16 mm
No. of teeth Z	4
Recess ⌀ D_1	15 mm

Balance quality with shank	G 2.5 with HA
Corner rounding r_v	0.32 mm
Overall length L	150 mm
Tolerance nominal ∅	e8
Shank ∅ D_s	16 mm
Helix angle	35 degrees
Overhang length L_1 incl. recess	96 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		