

**Garant**
**GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 18mm**

**Order data**

Order number	202012 18
GTIN	4062406126322
Item class	11X

**Description**
**Version:**

For roughing and finishing.

Up to 2×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.**

**Note:**

A minimum oversize of 0.1×D must be maintained for subsequent finishing operations.

**Technical description**

Shank Ø D <sub>s</sub>	18 mm
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Overall length L	117 mm
Cutting edge Ø D <sub>c</sub>	18 mm
Feed f <sub>z</sub> for slot milling in short-chipping aluminium	0.14 mm
Recess Ø D <sub>1</sub>	17.8 mm
Flute length L <sub>c</sub>	31 mm
Balance quality with shank	G 2.5 with HA

Overhang length $L_1$ incl. recess	67 mm
Tolerance nominal $\varnothing$	e8
Feed $f_z$ for side milling in short-chipping aluminium	0.16 mm
Shank	DIN 6535 HA to h6
Helix angle	42 degrees
Corner chamfer angle	90 degrees
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