

## Garant

### GARANT Master Alu PickPocket solid carbide roughing end mill with through-coolant HPC, DLC, Ø e8 DC: 10mm



#### Order data

Order number	202015 10
GTIN	4062406380960
Item class	11X

#### Description

##### Version:

For roughing and finishing.

Up to  $2 \times D$  into solid material at very high feed rates and smooth cutting action.

Very high feed rates when plunging vertically.

Ramping capability up to  $45^\circ$ .

Improved chip evacuation due to central through-coolant.

With the latest generation of DLC coating  $sp^2$ .

##### Advantage:

**Optimised flute form, eccentric relief ground, generous chip spaces.**

##### Note:

A minimum oversize of  $0.1 \times D$  must be maintained for subsequent finishing operations.

#### Technical description

Shank Ø $D_s$	10 mm
Overall length L	80 mm
Cutting edge Ø $D_c$	10 mm
No. of teeth Z	3
Corner rounding $r_v$	0.32 mm
Overhang length $L_1$ incl. recess	38 mm
Shank	DIN 6535 HA to h6
Helix angle	42 degrees

Feed $f_z$ for slot milling in short-chipping aluminium	0.06 mm
Balance quality with shank	G 2.5 with HA
Flute length $L_c$	22 mm
Direction of infeed	horizontal, oblique and vertical
Recess $\varnothing D_1$	9.8 mm
Feed $f_z$ for side milling in short-chipping aluminium	0.08 mm
Tolerance nominal $\varnothing$	e8
Series	Master Alu
Coating	DLC
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 $1 \times D$
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Through-coolant	yes
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	550 m/min	N
Aluminium (short chipping)	suitable	500 m/min	N
Alu > 10% Si	Suitable	450 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N

PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N
PVDF GF20	Suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	Suitable	150 m/min	N
PEEK GF30	Suitable	130 m/min	N
PTFE CF25	Suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	Suitable		
<b>Air Services</b>	Suitable		

Shank grinding Type HB

129100 HB