

**Garant**
**GARANT Master Alu PickPocket solid carbide roughing end mill HPC, DLC, Ø e8 DC: 8Mmm**

**Order data**

Order number	202004 8M
GTIN	4062406380922
Item class	11X

**Description**
**Version:**

With the latest generation of DLC coating sp<sup>2</sup>.

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.**

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 42°

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length L<sub>c</sub>: 21 mm

Overhang length L<sub>1</sub> incl. recess: 25 mm

Recess Ø D<sub>1</sub>: 7.8 mm

Overall length L: 63 mm

Shank Ø D<sub>s</sub>: 8 mm

**Technical description**

Corner rounding r <sub>v</sub>	0.2 mm
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Balance quality with shank	G 2.5 with HA
Feed $f_z$ for side milling in short-chipping aluminium	0.1 mm
Flute length $L_c$	21 mm
Shank	DIN 6535 HA to h6
Tolerance nominal $\varnothing$	e8
Helix angle	42°
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Shank $\varnothing D_s$	8 mm
Cutting edge $\varnothing D_c$	8 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.08 mm
Overhang length $L_1$ incl. recess	25 mm
Overall length L	63 mm
Recess $\varnothing D_1$	7.8 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
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	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
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		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	suitable		