

## Garant

### GARANT Master Alu PickPocket solid carbide roughing end mill HPC, uncoated, Ø e8 DC: 9,7 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 202002 9,7    |
| GTIN         | 4062406125783 |
| 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  $45^\circ$ .

##### Advantage:

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

Tolerance nominal Ø: e8

No. of teeth Z: 3

Helix angle: 42 degrees

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  $L_c$ : 22 mm

Overhang length  $L_1$  incl. recess: 30 mm

Recess Ø  $D_1$ : 9.5 mm

Overall length L: 72 mm

Shank Ø  $D_s$ : 10 mm

#### Technical description

|   |                                  |
|---|----------------------------------|
| Direction of infeed                                     | horizontal, oblique and vertical |
| Feed $f_z$ for side milling in short-chipping aluminium | 0.12 mm                          |

|   |                                      |
|---|--------------------------------------|
| Recess $\varnothing D_1$                                | 9.5 mm                               |
| Overhang length $L_1$ incl. recess                      | 30 mm                                |
| Tolerance nominal $\varnothing$                         | e8                                   |
| No. of teeth Z  | 3                                    |
| Helix angle   | 42 degrees                           |
| Balance quality with shank                              | G 2.5 with HA                        |
| Overall length L  | 72 mm                                |
| Shank   | DIN 6535 HA to h6                    |
| Cutting edge $\varnothing D_c$                          | 9.7 mm                               |
| Feed $f_z$ for slot milling in short-chipping aluminium | 0.09 mm                              |
| Shank $\varnothing D_s$                                 | 10 mm                                |
| Flute length $L_c$                                      | 22 mm                                |
| Corner chamfer angle                                    | 90 degrees                           |
| Series  | GARANT Master Alu                    |
| Coating   | uncoated                             |
| 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 $1 \times D$ |
| 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 mill                             |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|

