

Garant

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



Order data

Order number	202014 18
GTIN	4062406126421
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°.

With the latest generation of DLC coating sp².

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.

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: 31 mm

Overhang length L₁ incl. recess: 67 mm

Recess Ø D₁: 17.8 mm

Overall length L: 117 mm

Shank Ø D_s: 18 mm

Technical description

Shank	DIN 6535 HA to h6
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Tolerance nominal \varnothing	e8
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	67 mm
Feed f_z for slot milling in short-chipping aluminium	0.14 mm
Recess $\varnothing D_1$	17.8 mm
Shank $\varnothing D_s$	18 mm
Overall length L	117 mm
Flute length L_c	31 mm
Feed f_z for side milling in short-chipping aluminium	0.16 mm
Cutting edge $\varnothing D_c$	18 mm
No. of teeth Z	3
Balance quality with shank	G 2.5 with HA
Helix angle	42 degrees
Corner rounding r_v	0.32 mm
Series	GARANT 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 $1 \times D$
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