

**Garant**
**GARANT Master Alu PickPocket solid carbide roughing end mill HPC, DLC, Ø e6 DC: 20 mm**

**Order data**

Order number	202017 20
GTIN	4062406381073
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°.

Very long overhang for safe machining of deep cavities.

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

**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<sub>c</sub>: 32 mm

Overhang length L<sub>1</sub> incl. recess: 98 mm

Recess Ø D<sub>1</sub>: 19 mm

Overall length L: 150 mm

Shank Ø D<sub>s</sub>: 20 mm

**Technical description**

Shank	DIN 6535 HA to h6
No. of teeth Z	3
Feed $f_z$ for side milling in short-chipping aluminium	0.15 mm
Cutting edge $\varnothing D_c$	20 mm
Recess $\varnothing D_1$	19 mm
Feed $f_z$ for slot milling in short-chipping aluminium	0.12 mm
Helix angle	42 degrees
Shank $\varnothing D_s$	20 mm
Tolerance nominal $\varnothing$	e8
Overall length L	150 mm
Overhang length $L_1$ incl. recess	98 mm
Direction of infeed	horizontal, oblique and vertical
Balance quality with shank	G 2.5 with HA
Corner rounding $r_v$	0.2 mm
Flute length $L_c$	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	$0.3 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End mill

