

Garant

GARANT Master Alu PickPocket solid carbide roughing end mill with through-coolant HPC, DLC, Ø e6 DC: 6 mm



Order data

Order number	202019 6
GTIN	4062406381080
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°.

Improved chip evacuation due to central through-coolant.

Very long overhang for safe machining of deep cavities.

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: 10 mm

Overhang length L₁ incl. recess: 42 mm

Recess Ø D₁: 5.7 mm

Overall length L: 80 mm

Shank Ø D_s: 6 mm

Technical description

Helix angle	42 degrees
Shank	DIN 6535 HA to h6
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in short-chipping aluminium	0.06 mm
Overhang length L_1 incl. recess	42 mm
Feed f_z for slot milling in short-chipping aluminium	0.04 mm
Balance quality with shank	G 2.5 with HA
Tolerance nominal \varnothing	e8
Recess $\varnothing D_1$	5.7 mm
Overall length L	80 mm
Shank $\varnothing D_s$	6 mm
Flute length L_c	10 mm
Cutting edge $\varnothing D_c$	6 mm
No. of teeth Z	3
Corner rounding r_v	0.2 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×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End mill

