Garant

GARANT Master Alu SlotMachine solid carbide roughing end mill HPC, DLC, Ø e8 DC: 20 mm

Order data

Order number	205274 20
GTIN	4062406381301
Item class	11X

Description

Version:
For roughing.
Special profile for machining non-ferrous metals. Significant reduction in the chip volume due to targeted chip fragmentation using the **special cutter geometry.**
Problem-solver for **TPC machining.** Ideal for automated production as the risk of chip accumulations in the machine is largely prevented.
Note:
Please use tools with HB drive flats for particularly demanding roughing machining tasks. Can be ordered in the Hoffmann Group's e-shop.
For **HB shanks** use order **no. 205276**.
HB shanks are available at the same price as HA.
h_{max}: The values stated in the table are maximum values.
ae_{max} is 0.12 × D for TPC machining.
Tolerance nominal Ø: e8
No. of teeth Z: 4
Helix angle: 35 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: 4
Flute length L_c: 82 mm
Overhang length L_1 incl. recess: 100 mm
Recess Ø D_1: 19 mm
Overall length L: 150 mm
Shank Ø D_s: 20 mm

Technical description

Corner rounding r_v	0.5 mm
Shank	DIN 6535 HA to h6
Helix angle	35 degrees
Direction of infeed	horizontal, oblique and vertical
Recess ∅ D_1	19 mm
Average chip thickness h_{max} for TPC milling in short-chipping aluminium	0.13 mm
Overhang length L_1 incl. recess	100 mm
Balance quality with shank	G 2.5 with HA
Flute length L_c	82 mm
Tolerance nominal ∅	e8
No. of teeth Z	4
Shank ∅ D_s	20 mm
Overall length L	150 mm
Cutting edge ∅ D_C	20 mm
Series	GARANT Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer’s standard
Milling profile	WR
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.12×D
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End mill