

# GARANT Master Alu PickPocket solid carbide torus cutter HPC, DLC, Ø e6 DC / R1: 10/3,0 mm



### **Order data**

Order number	206261 10/3,0
GTIN	4062406398507
Item class	11X

## **Description**

#### **Version:**

Eccentric relief ground, additionally polish ground in the flutes for outstanding chip evacuation in long-chipping non-ferrous materials.

Very high feed rates when plunging vertically. Ramping capability up to 45°.

**Tolerances:** 

#### · Corner radius

 $R_1 = 0.5$  tolerance  $\pm 0.02$  mm.

 $R_1 > 0.5 - 1.5$  tolerance  $\pm 0.03$  mm.

 $R_1 > 1.5$  tolerance  $\pm 0.05$  mm.

No. of teeth Z: 3

Shank: DIN 6535 HA to h6

Balance quality with shank: G 2.5 with HA

No. of teeth Z: 3

Flute length  $L_c$ : 16 mm Corner radius  $R_1$ : 3 mm

Overhang length L<sub>1</sub> incl. recess: 68 mm

Recess Ø D₁: 9.2 mm Overall length L: 110 mm

## **Technical description**

Cutting edge Ø D <sub>c</sub>	10 mm
No. of teeth Z	3
Shank	DIN 6535 HA to h6

Balance quality with shank  Shank Ø D₂  10 mm  Overall length L  110 mm  Overhang length L₁ incl. recess  68 mm  Feed f₂ for copy milling in short-chipping aluminium  Recess Ø D₁  Feed f₂ for side milling in short-chipping aluminium  Flute length L₂  Series  GARANT Master Alu  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Tolerance nominal Ø  Helix angle characteristic  Spacing of the cutters  Direction of infeed  Cutting width a₂ for milling operation  Cutting width a₂ for milling operation  Machining strategy  Type of product  Full slot cutting  Jin mm  G2.5 with HA  10 mm  G2.5 with HA  110 mm  G2. with HA  110 mm  G2.5 with HA  110 mm  G2.5 with HA  110 mm  G2. with HA  110 mm  G2.5 with HA  120 milling  G3.5 with HA  120 milling  G4.5 with HA	Corner radius R <sub>1</sub>	3 mm
Overall length L Overhang length L₁ incl. recess 68 mm Feed f₂ for copy milling in short-chipping aluminium Recess Ø D₁ 9.2 mm Feed f₂ for side milling in short-chipping aluminium 0.05 mm Flute length L₂ 16 mm Series GARANT Master Alu Coating DLC Tool material Solid carbide Standard DIN 6527 Type W Tolerance nominal Ø Helix angle characteristic Spacing of the cutters Direction of infeed Cutting width a₂ for milling operation Cutting width a₂ for milling operation Full slot cutting depth 1×D Through-coolant Machining strategy Colour ring Full slot cutting yellow	Balance quality with shank	G 2.5 with HA
Overhang length L₁ incl. recess       68 mm         Feed f₂ for copy milling in short-chipping aluminium       0.06 mm         Recess Ø D₁       9.2 mm         Feed f₂ for side milling in short-chipping aluminium       0.05 mm         Flute length L₂       16 mm         Series       GARANT Master Alu         Coating       DLC         Tool material       Solid carbide         Standard       DIN 6527         Type       W         Tolerance nominal Ø       e8         Helix angle characteristic       unequal spacing         Spacing of the cutters       unequal spacing         Direction of infeed       horizontal, oblique and vertical         Cutting width a₂ for milling operation       0.5×D for side milling         Cutting width a₂ for milling operation       Full slot cutting depth 1×D         Through-coolant       no         Machining strategy       HPC         Colour ring       yellow	Shank Ø D <sub>s</sub>	10 mm
Feed $f_z$ for copy milling in short-chipping aluminium0.06 mmRecess $\varnothing$ $D_1$ 9.2 mmFeed $f_z$ for side milling in short-chipping aluminium0.05 mmFlute length $L_c$ 16 mmSeriesGARANT Master AluCoatingDLCTool materialSolid carbideStandardDIN 6527TypeWTolerance nominal $\varnothing$ e8Helix angle characteristicunequal spacingSpacing of the cuttersunequal spacingDirection of infeedhorizontal, oblique and verticalCutting width $a_e$ for milling operation $0.5 \times D$ for side millingCutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyHPCColour ringyellow	Overall length L	110 mm
Recess $\varnothing$ D <sub>1</sub> 9.2 mm  Feed f <sub>2</sub> for side milling in short-chipping aluminium 0.05 mm  Flute length L <sub>c</sub> 16 mm  Series GARANT Master Alu  Coating DLC  Tool material Solid carbide  Standard DIN 6527  Type W  Tolerance nominal $\varnothing$ e8  Helix angle characteristic unequal spacing  Spacing of the cutters unequal spacing  Direction of infeed horizontal, oblique and vertical  Cutting width a <sub>e</sub> for milling operation 7.5 moly for side milling  Cutting width a <sub>e</sub> for milling operation Full slot cutting depth 1×D  Through-coolant no  Machining strategy HPC  Colour ring yellow	Overhang length L <sub>1</sub> incl. recess	68 mm
Feed f₂ for side milling in short-chipping aluminium  Flute length L₂  Series  GARANT Master Alu  Coating  DLC  Tool material  Solid carbide  Standard  DIN 6527  Type  W  Tolerance nominal Ø  Helix angle characteristic  Spacing of the cutters  Unequal spacing  Direction of infeed  Cutting width a₂ for milling operation  Cutting width a₂ for milling operation  Through-coolant  Machining strategy  Colour ring  O.55 mm  O.05 volid carbide  Solid carbide  W  Tolerance nominal Ø  e8  Helix angle characteristic  Unequal spacing  horizontal, oblique and vertical  Cutting width a₂ for milling operation  O.5 volide milling  Full slot cutting depth 1 vol  Through-coolant  No  HPC  yellow	Feed f <sub>z</sub> for copy milling in short-chipping aluminium	0.06 mm
Flute length L <sub>c</sub> Series GARANT Master Alu Coating DLC Tool material Solid carbide Standard DIN 6527 Type W Tolerance nominal Ø e8 Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Direction of infeed horizontal, oblique and vertical Cutting width a <sub>e</sub> for milling operation Cutting width a <sub>e</sub> for milling operation Through-coolant no Machining strategy HPC Colour ring	Recess Ø D <sub>1</sub>	9.2 mm
Series GARANT Master Alu  Coating DLC  Tool material Solid carbide  Standard DIN 6527  Type W  Tolerance nominal Ø e8  Helix angle characteristic unequal spacing Spacing of the cutters unequal spacing Direction of infeed horizontal, oblique and vertical  Cutting width ae for milling operation Cutting width ae for milling operation Full slot cutting depth 1×D  Through-coolant no  Machining strategy HPC Colour ring	Feed f <sub>z</sub> for side milling in short-chipping aluminium	0.05 mm
Coating       DLC         Tool material       Solid carbide         Standard       DIN 6527         Type       W         Tolerance nominal Ø       e8         Helix angle characteristic       unequal spacing         Spacing of the cutters       unequal spacing         Direction of infeed       horizontal, oblique and vertical         Cutting width ae for milling operation       0.5×D for side milling         Cutting width ae for milling operation       Full slot cutting depth 1×D         Through-coolant       no         Machining strategy       HPC         Colour ring       yellow	Flute length L <sub>c</sub>	16 mm
Tool material  Solid carbide  Standard  DIN 6527  Type  W  Tolerance nominal Ø  e8  Helix angle characteristic  unequal spacing  Spacing of the cutters  unequal spacing  Direction of infeed  horizontal, oblique and vertical  Cutting width ae for milling operation  Cutting width ae for milling operation  Full slot cutting depth 1×D  Through-coolant  no  Machining strategy  HPC  Colour ring  Solid carbide  DIN 6527  W  The Standard  Pell spacing  Solid carbide  DIN 6527  W  Full spacing  Spacing  Full slot cutting  HPC  Special Spacing  Spacing  Spacing  HPC  Special Spacing  HPC  Special Spacing  Spacing  Spacing  Spacing  HPC  Special Spacing  Spacing  Spacing  Spacing  HPC  Special Spacing  Spacing  Spacing  Spacing  Spacing  HPC  Special Spacing	Series	GARANT Master Alu
Standard       DIN 6527         Type       W         Tolerance nominal Ø       e8         Helix angle characteristic       unequal spacing         Spacing of the cutters       unequal spacing         Direction of infeed       horizontal, oblique and vertical         Cutting width ae for milling operation       0.5×D for side milling         Cutting width ae for milling operation       Full slot cutting depth 1×D         Through-coolant       no         Machining strategy       HPC         Colour ring       yellow	Coating	DLC
Type W  Tolerance nominal Ø e8  Helix angle characteristic unequal spacing  Spacing of the cutters unequal spacing  Direction of infeed horizontal, oblique and vertical  Cutting width ae for milling operation 0.5×D for side milling  Cutting width ae for milling operation Full slot cutting depth 1×D  Through-coolant no  Machining strategy HPC  Colour ring yellow	Tool material	Solid carbide
Tolerance nominal Ø  Helix angle characteristic  Spacing of the cutters  Direction of infeed  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Through-coolant  Machining strategy  Colour ring  Pell slot cutting wellow  Pell slot  Pell slot	Standard	DIN 6527
Helix angle characteristic  Spacing of the cutters  Unequal spacing  Direction of infeed  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  Through-coolant  Machining strategy  HPC  Colour ring  yellow	Туре	W
Spacing of the cutters  Direction of infeed  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  Through-coolant  Machining strategy  HPC  Colour ring  yellow	Tolerance nominal Ø	e8
Direction of infeed  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Cutting width a <sub>e</sub> for milling operation  Full slot cutting depth 1×D  Through-coolant  no  Machining strategy  HPC  Colour ring  yellow	Helix angle characteristic	unequal spacing
Cutting width $a_e$ for milling operation $0.5 \times D$ for side millingCutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyHPCColour ringyellow	Spacing of the cutters	unequal spacing
Cutting width $a_e$ for milling operationFull slot cutting depth $1 \times D$ Through-coolantnoMachining strategyHPCColour ringyellow	Direction of infeed	horizontal, oblique and vertical
Through-coolant no  Machining strategy HPC  Colour ring yellow	Cutting width a <sub>e</sub> for milling operation	0.5×D for side milling
Machining strategy HPC Colour ring yellow	Cutting width a <sub>e</sub> for milling operation	Full slot cutting depth 1×D
Colour ring yellow	Through-coolant	no
•	Machining strategy	HPC
Type of product End mill	Colour ring	yellow
	Type of product	End mill