

**Garant****GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC / TPC, DLC, Ø e8 DC: 6mm****Order data**

Order number	205267 6
GTIN	4062406377397
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**.

Improved chip evacuation due to central through-coolant.

**Note:**

HB shanks are available at the same price as HA.

For **HB shanks** use order **no. 205268**.

Cutting data for TPC machining in the ToolScout.

**Technical description**

Flute length $L_c$	18 mm
Corner rounding $r_v$	0.2 mm
Recess $\varnothing D_1$	5.5 mm
Overhang length $L_1$ incl. recess	24 mm
Cutting edge $\varnothing D_c$	6 mm
Helix angle	35 degrees
Feed $f_z$ for side milling in short-chipping aluminium	0.1 mm
Balance quality with shank	G 2.5 with HA
Shank	DIN 6535 HA to h6

## Data sheet

Direction of infeed	horizontal, oblique and vertical
Overall length L	62 mm
Shank $\varnothing D_s$	6 mm
No. of teeth Z	3
Tolerance nominal $\varnothing$	e8
Feed $f_z$ for slot milling in short-chipping aluminium	0.08 mm
Series	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	$0.5 \times D$ for side milling
Cutting width $a_e$ for milling operation	Full slot cutting depth $1 \times D$
Cutting width $a_e$ for milling operation	$0.2 \times D$
Through-coolant	yes
Machining strategy	HPC
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

## User data

	Suitability	$V_c$	ISO code
Aluminium	Suitable	450 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	380 m/min	N

## Data sheet

PA 66	suitable only under restricted conditions	120 m/min	N
PEEK	suitable only under restricted conditions	100 m/min	N
Cu	Suitable	160 m/min	N
CuZn	Suitable	200 m/min	N
wet maximum	suitable		
Air	suitable		

### Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/205267-6>