Data sheet

GARANT Master Alu SlotMachine solid carbide roughing end mill with through-coolant HPC, DLC, ∅ e8 DC: 4mm

Order data

Order number	205255 4
GTIN	4062406122331
Item class	11X

Description

Version:
For roughing.
Special profile for machining non-ferrous metals.
Improved chip evacuation due to central through-coolant.
Advantage:
Optimised flute form, eccentric relief ground, generous chip spaces.
Up to 2 × D into solid material at very high feed rates and smooth cutting action.
Ramping capability up to 45°.
Very high feed rates when plunging vertically, thanks to **special plunging geometry**.
Note:
For **HB** shanks use order **No. 205256**.

Technical description

Feed f_z for slot milling in short-chipping aluminium	0.04 mm
Overall length L	57 mm
No. of teeth Z	3
Direction of infeed	horizontal, oblique and vertical
Helix angle	35 degrees
Shank	DIN 6535 HA to h6
Feed f_z for side milling in short-chipping aluminium	0.06 mm

Flute length L_c	8 mm
Tolerance nominal ∅	e8
Cutting edge ∅ D_C	4 mm
Balance quality with shank	G 2.5 with HA
Shank ∅ D_s	6 mm
Corner rounding r_v	0.1 mm
Series	Master Alu
Coating	DLC
Tool material	Solid carbide
Standard	DIN 6527
Milling profile	WR
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	Full slot cutting depth 1×D
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Through-coolant	yes
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
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/205255-4