

Garant**GARANT Master Alu SlotMachine solid carbide roughing end mill TPC, DLC, Ø e8 DC: 6mm****Order data**

Order number	205274 6
GTIN	4062406381257
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:

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 $0.15 \times D$ for TPC machining.

Technical description

Average chip thickness h_{\max} for TPC milling in short-chipping aluminium	0.043 mm
Overhang length L_1 incl. recess	30 mm
Cutting edge Ø D_c	6 mm
Direction of infeed	horizontal, oblique and vertical
Overall length L	70 mm
Helix angle	35 degrees
Balance quality with shank	G 2.5 with HA

Data sheet

Shank Ø D _s	6 mm
Corner rounding r _v	0.2 mm
Recess Ø D ₁	5.7 mm
No. of teeth Z	3
Shank	DIN 6535 HA to h6
Flute length L _c	25 mm
Tolerance nominal Ø	e8
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	0.15×D
Through-coolant	no
Machining strategy	HPC
Colour ring	yellow
Type of product	End / face mill

User data

	Suitability	V _c	ISO code
Aluminium	Suitable	400 m/min	N
Aluminium (short chipping)	Suitable	360 m/min	N
Alu > 10% Si	suitable	340 m/min	N
PA 66	suitable only under restricted conditions	110 m/min	N
PEEK	suitable only under restricted conditions	90 m/min	N

Data sheet

Cu	Suitable	140 m/min	N
CuZn	Suitable	180 m/min	N
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable only under restricted conditions		
Air	Suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/205274-6>