

**Garant****Solid carbide high feed rate milling cutter HFC, AlTiSiN, Ø h8 DC: 8mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 206269 8      |
| GTIN         | 4067263132691 |
| Item class   | 11Z           |

**Description****Version:**

Innovative ultra-fine grain substrate, especially for hard machining up to 70 HRC. Newly developed high-performance coating for outstanding tool life and optimum metal removal rate. Tolerance: Corner radius **R1 = +/- 0.01mm**

**Application:**

Especially for HFC machining in mould and tool making, for copy and traverse milling. Very high machining volume in hard machining.

**Note:**

**Successor product to No. 206273.**

**Technical description**

|                                    |            |
|------------------------------------|------------|
| Setting angle $\kappa$             | 15 degrees |
| Cutting edge $\varnothing D_c$     | 8 mm       |
| Flute length $L_c$                 | 7 mm       |
| Recess $\varnothing D_1$           | 7.8 mm     |
| Programming radius                 | 0.718 mm   |
| Shank $\varnothing D_s$            | 8 mm       |
| No. of teeth Z                     | 6          |
| Overhang length $L_1$ incl. recess | 20 mm      |
| Dimension $a_{p \max}$ transverse  | 0.65 mm    |
| Overall length L                   | 70 mm      |

|                                               |                                  |
|-----------------------------------------------|----------------------------------|
| Corner radius $R_1$                           | 0.4 mm                           |
| End radius $R_3$                              | 9.6 mm                           |
| Feed $f_z$ for side milling in steel < 55 HRC | 0.316 mm                         |
| Coating                                       | AlTiSiN                          |
| Tool material                                 | solid carbide                    |
| Standard                                      | Manufacturer's standard          |
| Type                                          | N                                |
| Tolerance nominal $\varnothing$               | h8                               |
| Helix angle                                   | 20 degrees                       |
| Direction of infeed                           | horizontal, oblique and vertical |
| Shank                                         | DIN 6535 HA to h5                |
| Through-coolant                               | no                               |
| Machining strategy                            | HFC                              |
| Colour ring                                   | red                              |
| Type of product                               | End torus mill                   |

## User data

|                | Suitability                               | $V_c$     | ISO code |
|----------------|-------------------------------------------|-----------|----------|
| Steel < 50 HRC | suitable                                  | 105 m/min | H        |
| Steel < 55 HRC | suitable                                  | 105 m/min | H        |
| Steel < 60 HRC | suitable                                  | 75 m/min  | H        |
| Steel < 65 HRC | suitable                                  | 64 m/min  | H        |
| Steel < 67 HRC | suitable                                  | 53 m/min  | H        |
| Steel < 70 HRC | suitable                                  | 53 m/min  | H        |
| wet maximum    | suitable only under restricted conditions |           |          |
| dry            | suitable                                  |           |          |

## Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/206269-8>

