

Garant**Solid carbide high feed rate milling cutter HFC, AlTiSiN, Ø h8 DC: 12mm****Order data**

Order number	206269 12
GTIN	4067263133117
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

No. of teeth Z	6
Overall length L	90 mm
Dimension $a_{p \max}$ transverse	0.9 mm
Recess Ø D ₁	11.7 mm
Shank Ø D _s	12 mm
Overhang length L ₁ incl. recess	30 mm
Programming radius	1 mm
Setting angle κ	15 degrees
Flute length L _c	12 mm
Cutting edge Ø D _c	12 mm

Corner radius R_1	0.5 mm
End radius R_3	14.4 mm
Feed f_z for side milling in steel < 55 HRC	0.444 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/206269-12>

