

Garant**Solid carbide high feed rate milling cutter HFC, AlTiSiN, Ø h8 DC: 5mm****Order data**

Order number	206269 5
GTIN	4067263132677
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

Flute length L_c	4 mm
Overhang length L_1 incl. recess	15 mm
Recess $\varnothing D_1$	4.8 mm
Overall length L	57 mm
Cutting edge $\varnothing D_c$	5 mm
Programming radius	0.45 mm
Shank $\varnothing D_s$	6 mm
Setting angle κ	9.5 degrees
No. of teeth Z	6
Dimension $a_{p\max}$ transverse	0.41 mm

Corner radius R_1	0.25 mm
End radius R_3	6 mm
Feed f_z for side milling in steel < 55 HRC	0.191 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/206269-5>

