Data sheet

Garant

GARANT GreenPlus solid carbide milling cutter HPC, TiAlN, ⌀ f8 DC: 12mm

Order data

Order number	203055 12
GTIN	4067263135739
Item class	11Z

Description

Version:
For **roughing and finishing** with **very high cutting data. Optimised core geometry** ensures a **low tendency to vibrate** and thus significantly **increased tensile strength**. **Innovative geometry and high-performance coating** allow the machining of **different materials** while maintaining **high temperature resistance.**
Advantage:
In the milling cutter range of the Hoffmann Group, the production of the **micrograin carbide substrate rod** currently has the **lowest product-specific CO_2 emissions**, thus **reducing the environmental footprint** compared to conventionally produced carbide rods.

Technical description

Overall length L	83 mm
Corner chamfer angle	45 degrees
Overhang length L_1 incl. recess	36 mm
Flute length L_c	26 mm
Feed f_z for slot milling in stainless steel > 900 N/mm^2	0.04 mm
Corner chamfer width at 45°	0.3 mm
Feed f_z for side milling in INOX > 900 N/mm^2	0.05 mm
Recess ⌀ D_1	11.6 mm
Cutting edge ⌀ D_C	12 mm

Helix angle	35 degrees
Shank	DIN 6535 HB to h6
Feed f_z for side milling in steel < 900 N/mm^2	0.09 mm
Feed f_z for slot milling in steel < 900 N/mm^2	0.07 mm
Shank ∅ D_s	12 mm
No. of teeth Z	4
Tolerance nominal ∅	f8
Direction of infeed	horizontal, oblique and vertical
Sustainability	GARANT GreenPlus
Series	GreenPlus
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	0.3×D for side milling
Cutting width a_e for milling operation	0.3×D for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	blue
Type of product	Indexable end mill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm^2	suitable	250 m/min	P
Steel < 750 N/mm^2	suitable	230 m/min	P
Steel < 900 N/mm^2	suitable	190 m/min	P
Steel < 1100 N/mm^2	suitable	180 m/min	P

Steel < 1400 N/mm²	suitable	150 m/min	P
INOX < 900 N/mm²	suitable	100 m/min	M
INOX > 900 N/mm²	suitable	90 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	220 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		