

Garant**GARANT GreenPlus solid carbide milling cutter HPC, TiAlN, Ø f8 DC: 20mm****Order data**

Order number	203055 20
GTIN	4067263135753
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 CO₂ emissions**, thus **reducing the environmental footprint** compared to conventionally produced carbide rods.

Technical description

Feed f_z for slot milling in steel < 900 N/mm ²	0.1 mm
Feed f_z for side milling in INOX > 900 N/mm ²	0.08 mm
No. of teeth Z	4
Feed f_z for side milling in steel < 900 N/mm ²	0.13 mm
Flute length L_c	41 mm
Overall length L	104 mm
Shank	DIN 6535 HB to h6
Helix angle	35 degrees
Corner chamfer width at 45°	0.3 mm

Data sheet

Shank $\varnothing D_s$	20 mm
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	20 mm
Corner chamfer angle	45 degrees
Tolerance nominal $\varnothing$	f8
Recess $\varnothing D_1$	19.5 mm
Feed f_z for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.07 mm
Overhang length L_1 incl. recess	52 mm
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	$0.3 \times D$ for side milling
Cutting width a_e for milling operation	$0.3 \times D$ 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 $< 500 \text{ N/mm}^2$	suitable	250 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	230 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	190 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	180 m/min	P

Data sheet

Steel < 1400 N/mm ²	suitable	150 m/min	P
INOX < 900 N/mm ²	suitable	100 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M
Ti > 850 N/mm ²	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		