


**GARANT GreenPlus solid carbide milling cutter HPC, TiAlN, Ø f8 DC: 6mm**

**Order data**

Order number	203055 6
GTIN	4067263135708
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<sub>2</sub> emissions**, thus **reducing the environmental footprint** compared to conventionally produced carbide rods.

**Technical description**

Corner chamfer width at 45°	0.1 mm
Feed $f_z$ for side milling in INOX > 900 N/mm <sup>2</sup>	0.025 mm
Tolerance nominal Ø	f8
Helix angle	35 degrees
Cutting edge Ø D <sub>c</sub>	6 mm
Overall length L	57 mm
Shank	DIN 6535 HB to h6
Overhang length L <sub>1</sub> incl. recess	19 mm
Corner chamfer angle	45 degrees
Direction of infeed	horizontal, oblique and vertical

## Data sheet

Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.045 mm
Shank $\varnothing D_s$	6 mm
Feed $f_z$ for slot milling in stainless steel $> 900 \text{ N/mm}^2$	0.02 mm
Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.035 mm
No. of teeth Z	4
Recess $\varnothing D_1$	5.8 mm
Flute length $L_c$	13 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
Steel $< 1400 \text{ N/mm}^2$	suitable	150 m/min	P

## Data sheet

INOX < 900 N/mm <sup>2</sup>	suitable	100 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	90 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		