

**Garant****GARANT GreenPlus solid carbide milling cutter HPC, TiAlN, Ø f8 DC: 8mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 203055 8      |
| GTIN         | 4067263135715 |
| 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**

|                                                                                 |                                  |
|---------------------------------------------------------------------------------|----------------------------------|
| Direction of infeed                                                             | horizontal, oblique and vertical |
| Shank Ø D <sub>s</sub>                                                          | 8 mm                             |
| Feed f <sub>z</sub> for side milling in INOX > 900 N/mm <sup>2</sup>            | 0.03 mm                          |
| Flute length L <sub>c</sub>                                                     | 21 mm                            |
| Feed f <sub>z</sub> for slot milling in stainless steel > 900 N/mm <sup>2</sup> | 0.025 mm                         |
| Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>           | 0.045 mm                         |
| Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>           | 0.055 mm                         |
| Corner chamfer angle                                                            | 45 degrees                       |
| Tolerance nominal Ø                                                             | f8                               |

## Data sheet

|                                           |                         |
|-------------------------------------------|-------------------------|
| Cutting edge $\varnothing D_c$            | 8 mm                    |
| Helix angle                               | 35 degrees              |
| Overhang length $L_1$ incl. recess        | 25 mm                   |
| No. of teeth Z                            | 4                       |
| Overall length L                          | 63 mm                   |
| Recess $\varnothing D_1$                  | 7.7 mm                  |
| Corner chamfer width at 45°               | 0.2 mm                  |
| Shank                                     | DIN 6535 HB to h6       |
| 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 <sup>2</sup>  | suitable    | 250 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 230 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 190 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 180 m/min | P        |

## Data sheet

|                                |                                              |           |   |
|--------------------------------|----------------------------------------------|-----------|---|
| Steel < 1400 N/mm <sup>2</sup> | suitable                                     | 150 m/min | P |
| 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<br>restricted conditions | 40 m/min  | S |
| GG(G)                          | suitable                                     | 220 m/min | K |
| Uni                            | suitable                                     |           |   |
| wet maximum                    | suitable                                     |           |   |
| wet minimum                    | suitable only under<br>restricted conditions |           |   |
| dry                            | suitable                                     |           |   |
| Air                            | suitable                                     |           |   |