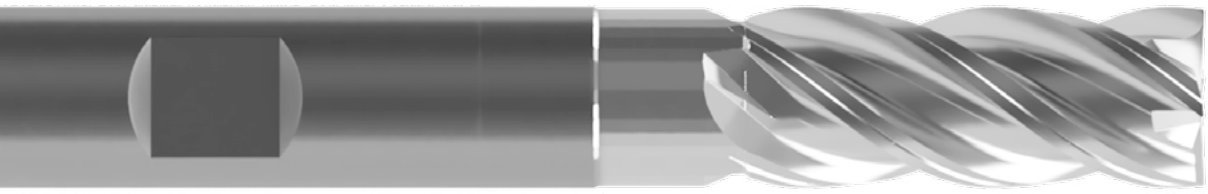
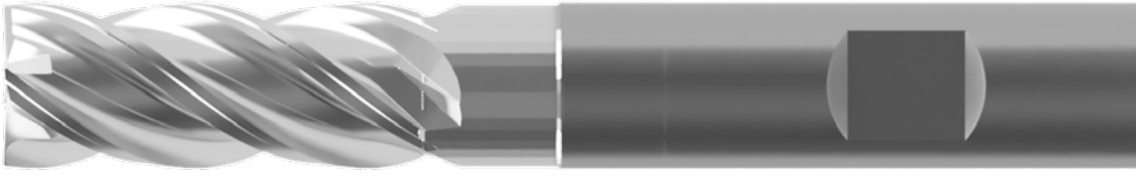
HB Microtec
ACTIONTOOLS & ENGINEERING



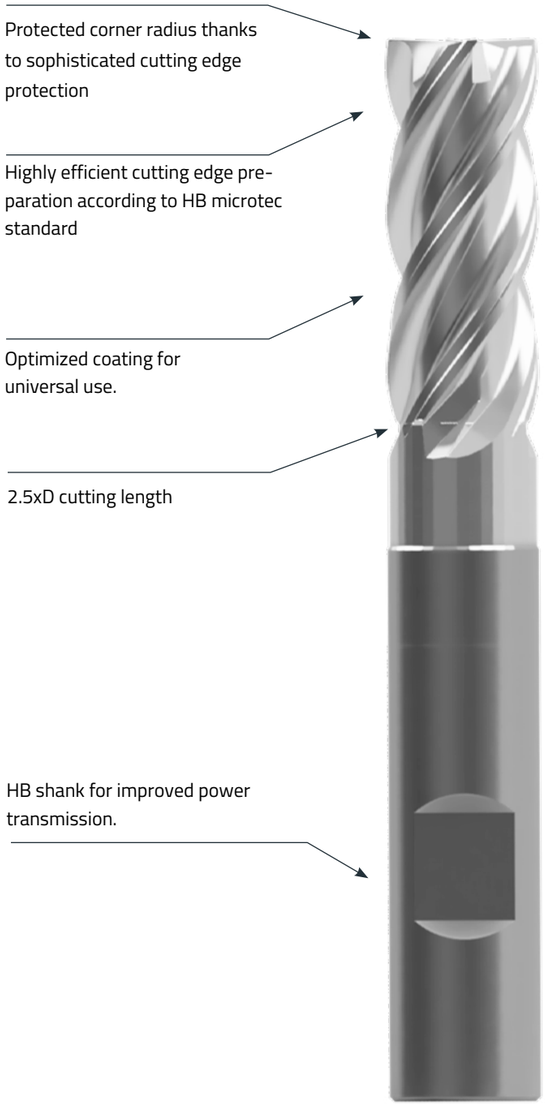
ACTIONMILL

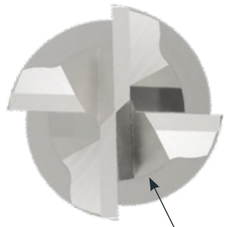
by HB microtec

GRIZZLY-Groover

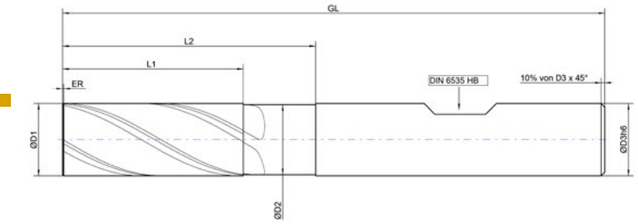


GRIZZLY Groover





Cylindrical core design for greater stability and vibration damping effect

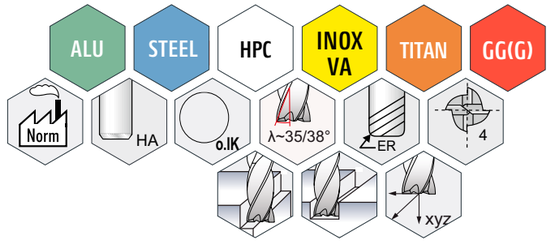


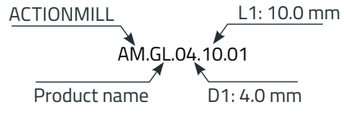
☐ **Order** **Order number:** _____ ☐ **Inquiry**

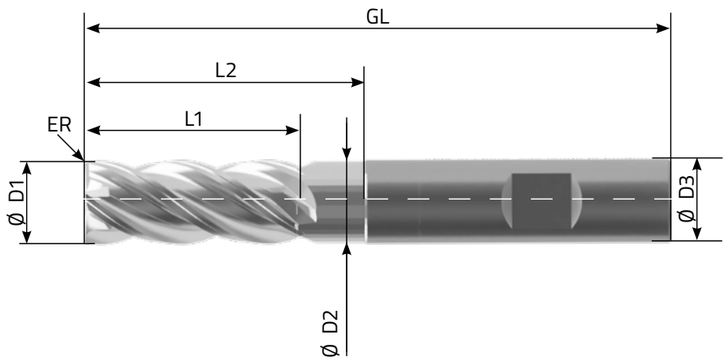
Dimensions: D_1: _____ GL: _____ ER: _____ D_2: _____ L_1: _____ Z: _____ D_3: _____ L_2: _____	**Coating:** ☐ Coated*: _____ ☐ Uncoated	**Cooling channels:** ☐ Yes ☐ No **Cutting direction:** ☐ Left ☐ Right
Material to be machined:	**Shank shape:**	**Quantity:**
Date, signature & company stamp:		**Contact person:**

* Without further information, the most suitable coating will be used.

GRIZZLY Groover







- α-INOX coated

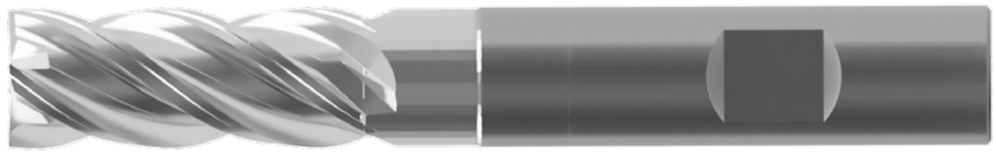
5 PRO's of the ACTIONMILL:

- High-performance-HPC-Mill from Ø4 up to Ø16
- Roughing & finishing of demanding materials

  such as CoCr or INOX
- Long tool life and process reliability
- Universally applicable
- Perfect price-performance ratio

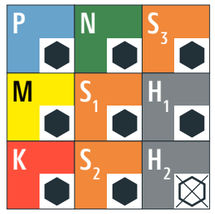
Article number	D1 (mm)	D2 (mm)	D3 h6 (mm)	L1 (mm)	L2 (mm)	ER (mm)	GL (mm)
AM.GL.04.10.01	Ø4.00	Ø3.70	Ø6.00	10.00	20.00	0.08	58.00
AM.GL.05.13.01	Ø5.00	Ø4.70	Ø6.00	13.00	23.00	0.08	58.00
AM.GL.06.15.01	Ø6.00	Ø5.70	Ø6.00	15.00	25.00	0.10	58.00
AM.GL.08.20.01	Ø8.00	Ø7.70	Ø8.00	20.00	30.00	0.10	64.00
AM.GL.10.25.01	Ø10.00	Ø9.70	Ø10.00	25.00	35.00	0.15	73.00
AM.GL.12.30.01	Ø12.00	Ø11.70	Ø12.00	30.00	40.00	0.15	84.00
AM.GL.14.35.01	Ø14.00	Ø13.70	Ø14.00	35.00	45.00	0.25	93.00
AM.GL.16.40.01	Ø16.00	Ø15.70	Ø16.00	40.00	50.00	0.25	93.00

Available from stock



Cutting data - ACTIONMILL GRIZZLY Groover

ACTIONMILL® by HB microtec GRIZZLY-Groover



Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
			CrCoMo28	ASTM F1537
H	Hardened steels ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

Recommended use | ⬢ Highly suitable | ⬡ Partially suitable | ⊠ Not recommended

ap=1xD	ae=1/2xD	ap=1xD	ae=1/2xD	ap=1xD	ae=1/2xD	ap=1xD	ae=1/2xD	ap=1xD	ae=1/2xD
Ø 4.0 mm -Ø 5.0 mm		Ø 6.0 mm - Ø 8.0 mm		Ø 10.0 mm - Ø 12.0 mm		Ø 14.0 mm		Ø 16.0 mm	
vc [m/min]	fz [mm]	vc [m/min]	fz [mm]	vc [m/min]	fz [mm]	vc [m/min]	fz [mm]	vc [m/min]	fz [mm]
100-140	0.02 - 0.035	100-140	0.03 - 0.045	100-140	0.05 - 0.065	100-150	0.06 - 0.075	100-160	0.07 - 0.085
100-140	0.02 - 0.03	100-140	0.03 - 0.04	100-140	0.05 - 0.055	100-150	0.06 - 0.065	100-160	0.07 - 0.075
80-110	0.02 - 0.03	80-110	0.035 - 0.045	80-110	0.045 - 0.055	80-130	0.055 - 0.065	80-130	0.065 - 0.075
70-100	0.015 - 0.025	70-100	0.035 - 0.045	70-100	0.045 - 0.055	70-120	0.055 - 0.065	70-140	0.065 - 0.075
80-140	0.02 - 0.04	80-140	0.04 - 0.055	80-140	0.05 - 0.065	80-140	0.06 - 0.065	80-160	0.065 - 0.085
80-160	0.02 - 0.04	80-160	0.035 - 0.06	80-160	0.055 - 0.06	80-160	0.055 - 0.06	80-160	0.065 - 0.075
80-140	0.02 - 0.045	80-160	0.035 - 0.06	80-160	0.055 - 0.06	80-180	0.055 - 0.06	80-180	0.065 - 0.08
80-120	0.02 - 0.045	80-140	0.035 - 0.06	80-140	0.055 - 0.06	80-160	0.055 - 0.06	80-160	0.065 - 0.085
50-100	0.02 - 0.03	50-120	0.03 - 0.04	50-120	0.03 - 0.05	50-120	0.04 - 0.06	50-120	0.05 - 0.07
50-100	0.02 - 0.03	50-120	0.03 - 0.04	50-120	0.03 - 0.05	50-120	0.04 - 0.06	50-120	0.05 - 0.07
50-100	0.02 - 0.03	50-120	0.03 - 0.04	50-120	0.03 - 0.05	50-120	0.04 - 0.06	50-120	0.05 - 0.07
no data available									
no data available									

ACTIONMILL®

by HB microtec

GRIZZLY-Groover

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ACTIONTOOLS & ENGINEERING

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