


HAIMER MILL end mill, AlTiN, Ø f9 DC: 6mm

Order data

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| Order number | 220286 6 |
| GTIN | 4034221161581 |
| Item class | 26X |

Description
Version:

For **general-purpose use** in steel materials and high-alloy steels, especially stainless steel. With **cylindrical core** for optimised tool stiffness when milling slots. Reliable processes guaranteed when ramping and during circular interpolation milling thanks to **special end face geometry**.

Note:

Tool holders with the SAFE-LOCK pull-out protection can be found under clamping technology. For **HB** use order **No. 220287**.

Technical description

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|---|-------------------|
| Recess Ø D ₁ | 5.7 mm |
| Helix angle | 32 degrees |
| Tolerance nominal Ø | f8 |
| Feed f _z for slot milling in steel < 900 N/mm ² | 0.033 mm |
| Shank Ø D _s | 6 mm |
| Overhang length L ₁ incl. recess | 20 mm |
| Corner chamfer angle | 45 degrees |
| Flute length L _c | 13 mm |
| No. of teeth Z | 4 |
| Shank | DIN 6535 HA to h6 |
| Overall length L | 58 mm |

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|--|----------------------------------|
| Corner chamfer width at 45° | 0.12 mm |
| Cutting edge $\varnothing D_c$ | 6 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Feed f_z for side milling in steel < 900 N/mm ² | 0.039 mm |
| Coating | AlTiN |
| Tool material | Solid carbide |
| Standard | DIN 6527 |
| Type | N |
| Helix angle characteristic | unequal spacing |
| Spacing of the cutters | unequal spacing |
| Cutting width a_e for milling operation | 0.5×D for side milling |
| Cutting width a_e for milling operation | Full slot cutting depth 1×D |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | without |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Alu plastics | suitable only under restricted conditions | | |
| Aluminium (short chipping) | suitable only under restricted conditions | 480 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 350 m/min | N |
| Steel < 500 N/mm ² | suitable | 275 m/min | P |
| Steel < 750 N/mm ² | suitable | 255 m/min | P |
| Steel < 900 N/mm ² | suitable | 210 m/min | P |
| Steel < 1100 N/mm ² | suitable | 190 m/min | P |
| INOX < 900 N/mm ² | suitable | 95 m/min | M |

| | | | |
|------------------------------|---|----------|---|
| INOX > 900 N/mm ² | suitable | 75 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | | |
| GG(G) | suitable only under restricted conditions | | |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| dry | suitable | | |
| Air | suitable | | |