HAIMER MILL end mill, AlTiN, ⌀ f9 DC: 3mm

Order data

Order number	220289 3
GTIN	4034221136787
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:
For **HB** use order **No. 220291**.
Tool holders with the SAFE-LOCK pull-out protection can be found under clamping technology.

Technical description

No. of teeth Z	4
Overhang length L_1 incl. recess	10 mm
Tolerance nominal ⌀	f8
Cutting edge ⌀ D_C	3 mm
Helix angle	32 degrees
Feed f_z for slot milling in steel < 900 N/mm^2	0.017 mm
Shank	DIN 6535 HA to h6
Direction of infeed	horizontal, oblique and vertical
Corner chamfer angle	90 degrees
Recess ⌀ D_1	2.9 mm
Overall length L	58 mm

Shank ∅ D_s	6 mm
Flute length L_c	8 mm
Feed f_z for side milling in steel < 900 N/mm²	0.02 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	480 m/min	N
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/mm²	suitable	275 m/min	P
Steel < 750 N/mm²	suitable	255 m/min	P
Steel < 900 N/mm²	suitable	210 m/min	P
Steel < 1100 N/mm²	suitable	190 m/min	P
INOX < 900 N/mm²	suitable	95 m/min	M
INOX > 900 N/mm²	suitable	75 m/min	M

Ti > 850 N/mm²	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable only under restricted conditions	155 m/min	K
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		