


HAIMER MILL solid carbide torus cutter, AlTiN, Ø f9 DC / R1: 8/1,5mm

Order data

Order number	220296 8/1,5
GTIN	4034221141132
Item class	26X

Description
Version:

For **general-purpose use** in steel materials and high-alloy steels, especially stainless steel. With **cylindrical core** for optimum 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. 220297**.

Tool arbor with the SAFE-LOCK pull-out protection can be found under clamping technology.

Technical description

Helix angle	32 degrees
Corner radius R_1	1.5 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.044 mm
Shank $\varnothing D_s$	8 mm
Shank	DIN 6535 HA to h6
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.052 mm
No. of teeth Z	4
Overhang length L_1 incl. recess	26 mm
Cutting edge $\varnothing D_c$	8 mm
Recess $\varnothing D_1$	7.6 mm
Overall length L	64 mm

Flute length L_c	19 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Tolerance nominal \varnothing	f9
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Type of product	Torus cutter

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	375 m/min	N
Steel < 500 N/mm ²	Suitable		
Steel < 750 N/mm ²	Suitable		
Steel < 900 N/mm ²	Suitable		
Steel < 1100 N/mm ²	Suitable		
INOX < 900 N/mm ²	Suitable		
INOX > 900 N/mm ²	Suitable		

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