



HAIMER MILL solid carbide torus cutter, AlTiN, Ø f9 DC / R1: 5/1,0mm



Order data

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|--------------|---------------|
| Order number | 220296 5/1,0 |
| GTIN | 4034221143006 |
| 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

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|---|-------------------|
| Cutting edge Ø D _c | 5 mm |
| Feed f _z for side milling in steel < 900 N/mm ² | 0.033 mm |
| Overall length L | 58 mm |
| Shank Ø D _s | 6 mm |
| Flute length L _c | 13 mm |
| Corner radius R ₁ | 1 mm |
| Shank | DIN 6535 HA to h6 |
| Recess Ø D ₁ | 4.8 mm |
| Helix angle | 32 degrees |
| No. of teeth Z | 4 |
| Feed f _z for slot milling in steel < 900 N/mm ² | 0.028 mm |

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|---|--------------------------------------|
| Overhang length L_1 incl. recess | 18 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 | | |

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|----------------------------|---|
| 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 |