



HAIMER MILL solid carbide torus cutter SAFE-LOCK, AlTiN, Ø f9 DC / R1: 16/3,0mm



Order data

Order number	220298 16/3,0
GTIN	4034221143495
Item class	26X

Description

Version:

With SAFE-LOCK pull-out protection to provide an additional form fit for the tool. In conjunction with SAFE-LOCK tool holders, it secures the tool to prevent it being pulled out.

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:

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

Technical description

Overhang length L_1 incl. recess	42.5 mm
Shank	Safe-Lock h6
No. of teeth Z	4
Helix angle	32 degrees
Cutting edge $\varnothing D_c$	16 mm
Corner radius R_1	3 mm
Shank $\varnothing D_s$	16 mm
Overall length L	93 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.088 mm

Flute length L_c	32 mm
Recess $\varnothing D_1$	15.2 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.104 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Tolerance nominal \varnothing	f8
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	480 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	480 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	375 m/min	N
Steel $< 500 \text{ N/mm}^2$	Suitable	275 m/min	P
Steel $< 750 \text{ N/mm}^2$	Suitable	255 m/min	P
Steel $< 900 \text{ N/mm}^2$	Suitable	210 m/min	P
Steel $< 1100 \text{ N/mm}^2$	Suitable	190 m/min	P
INOX $< 900 \text{ N/mm}^2$	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	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		