


DUO-LOCK HAIMER MILL Power Series HPC, AlTiN, Ø f9 D1: 12mm

Order data

Order number	220320 12
GTIN	4034221134219
Item class	26Y

Description
Version:

DUO-LOCK HAIMER MILL: Can be used as a universal tool. Unique end face geometry for ramping and circular interpolation milling. First choice for applications with short overhangs.

DUO-LOCK HAIMER MILL Power Series: First choice for applications with long overhangs and unstable clamping conditions. For particularly smooth running on long overhangs it is preferable to use solid carbide extensions.

Technical description

Overall length L	24 mm
Corner chamfer angle	45 degrees
Flute length L ₂	18 mm
DUO-LOCK interface	DL12
Ø D ₂	11.5 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.015 mm
Corner chamfer width at 45°	0.24 mm
Cutter Ø D	12 mm
Width across flats AF	9.5 mm
Overhang L ₁	18 mm

recommended tightening torque	30 Nm
Tolerance nominal \varnothing	f8
Number of cutting edges Z	4
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Helix angle	37 degrees
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.5×D for side milling
Machining strategy	HPC
Through-coolant	no
suitable arbor	with threaded shank
Type of product	Cutter insert for milling

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	240 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	240 m/min	N
Alu > 10% Si	suitable only under restricted conditions	120 m/min	N
Steel < 500 N/mm ²	suitable	200 m/min	P
Steel < 750 N/mm ²	suitable	170 m/min	P
Steel < 900 N/mm ²	suitable	110 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P

INOX < 900 N/mm ²	suitable only under restricted conditions	40 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
GG(G)	suitable only under restricted conditions	110 m/min	K
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		