


DUO-LOCK HAIMER MILL Power Series HPC, AlTiN, Ø f9 D1/R: 12/1,0mm

Order data

Order number	220334 12/1,0
GTIN	4034221141521
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

DUO-LOCK interface	DL12
Flute length L_2	18 mm
$\varnothing D_2$	11.5 mm
Overall length L	24 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.03 mm
Width across flats AF	9.5 mm
Cutter $\varnothing D$	12 mm
Overhang L_1	18 mm
recommended tightening torque	30 Nm
Tolerance nominal \varnothing	f8
Number of cutting edges Z	4

Corner radius	1 mm
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	$0.5 \times D$ 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		