


DUO-LOCK HAIMER MILL Power Series HPC, AlTiN, Ø f9 D1/R: 12/4,0mm

Order data

| | |
|--------------|---------------|
| Order number | 220334 12/4,0 |
| GTIN | 4034221141620 |
| 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

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

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|---|----------------------------------|
| Corner radius | 4 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 | | |