



DUO-LOCK HAIMER MILL Power Series HPC, AlTiN, Ø f9 D1/R: 12/2,0mm



Order data

Order number	220334 12/2,0
GTIN	4034221141569
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

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

Corner radius	2 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		