DUO-LOCK HAIMER MILL Power Series TPC, AlTiN, ⌀ h9 D1: 10mm

Order data

Order number	220326 10
GTIN	4034221102997
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.
Note:
h_{max}: The values stated in the table are maximum values.
$ae_{max} = 0.05 \times D$ for TPC machining.

Technical description

recommended tightening torque	20 Nm
DUO-LOCK interface	DL10
Overall length L	20 mm
Flute length L_2	15 mm
Average chip thickness h_{max} for TPC milling in steel < 900 N/mm^2	0.026 mm
⌀ D_2	9.6 mm
Corner chamfer angle	45 degrees
Corner chamfer width at 45°	0.3 mm

Number of cutting edges Z	5
Cutter ∅ D	10 mm
Tolerance nominal ∅	h9
Width across flats AF	8 mm
Overhang L_1	15 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle	46 degrees
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a_e for milling operation	0.05×D
Machining strategy	TPC
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	700 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	700 m/min	N
Alu > 10% Si	suitable only under restricted conditions	235 m/min	N
Steel < 500 N/mm²	suitable	220 m/min	P
Steel < 750 N/mm²	suitable	180 m/min	P
Steel < 900 N/mm²	suitable	160 m/min	P
Steel < 1100 N/mm²	suitable	120 m/min	P

INOX < 900 N/mm²	suitable only under restricted conditions	80 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions		
GG(G)	suitable only under restricted conditions	130 m/min	K
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		