



## DUO-LOCK HAIMER MILL Power Series TPC, AlTiN, Ø h9 D1: 20mm



### Order data

Order number	220326 20
GTIN	4034221103321
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

Width across flats AF	16 mm
Flute length $L_2$	30 mm
Overhang $L_1$	30 mm
Average chip thickness $h_{\max}$ for TPC milling in steel < 900 N/mm <sup>2</sup>	0.039 mm
Cutter Ø D	20 mm
Ø $D_2$	19.3 mm
Overall length L	40 mm
recommended tightening torque	80 Nm

Corner chamfer angle	45 degrees
Corner chamfer width at 45°	0.6 mm
Tolerance nominal Ø	h9
Number of cutting edges Z	5
DUO-LOCK interface	DL20
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/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	120 m/min	P

INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		