



DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 12mm



Order data

Order number	220348 12
GTIN	4034221116017
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

Ø D ₂	11.5 mm
Cutter Ø D	12 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.065 mm
Width across flats AF	9.5 mm
recommended tightening torque	30 Nm
DUO-LOCK interface	DL12
Overhang L ₁	9 mm
Tolerance nominal Ø	f9
Overall length L	15 mm
Number of cutting edges Z	4

Feed f_z for copy milling in steel $< 900 \text{ N/mm}^2$	0.03 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Helix angle	32 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
Cutting width a_e for milling operation	$0.5 \times D$ for copy 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	700 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	700 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	235 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	180 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	160 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	120 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable only under restricted conditions	80 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions		
Ti > 850 N/mm ²	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		