


DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 6mm

Order data

Order number	220314 6
GTIN	4034221139986
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

Corner chamfer angle	90 degrees
Overhang L_1	9 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.018 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.036 mm
Flute length L_2	9 mm
recommended tightening torque	20 Nm
DUO-LOCK interface	DL10
Cutter $\varnothing D$	6 mm
Tolerance nominal \varnothing	f8
Overall length L	20 mm

Ø D ₂	9.6 mm
Width across flats AF	8 mm
Number of cutting edges Z	3
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Helix angle	36 degrees
Helix angle characteristic	unequal spacing
Direction of infeed	horizontal, oblique and vertical
Cutting width a _e for milling operation	Full slot cutting depth 1×D
Cutting width a _e for milling operation	0.05×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	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 ²	suitable	220 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	160 m/min	P
Steel < 1100 N/mm ²	suitable	120 m/min	P

INOX < 900 N/mm ²	suitable only under restricted conditions	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	60 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
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		