

**DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 20mm****Order data**

Order number	220314 20
GTIN	4034221103338
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	80 Nm
DUO-LOCK interface	DL20
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.05 mm
Corner chamfer angle	90 degrees
Width across flats AF	16 mm
Cutter $\varnothing D$	20 mm
$\varnothing D_2$	19.3 mm
Tolerance nominal \varnothing	f8
Overall length L	40 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.09 mm

Flute length L_2	30 mm
Overhang L_1	30 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 $1 \times D$
Cutting width a_e for milling operation	$0.05 \times D$ 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	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		