



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



Order data

Order number	220312 12
GTIN	4034221103130
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:

Standard application values for slots milled from solid at $a_{pmax} \leq 0.5 \times D$.

Technical description

Tolerance nominal Ø	f8
Overall length L	15 mm
Flute length L ₂	9 mm
Overhang L ₁	9 mm
Ø D ₂	11.5 mm
DUO-LOCK interface	DL12
Cutter Ø D	12 mm
Feed f _z for slot milling in steel < 900 N/mm ²	0.03 mm

Corner chamfer angle	90 degrees
Width across flats AF	9.5 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.065 mm
recommended tightening torque	30 Nm
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	0.05×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
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		
Steel < 750 N/mm ²	suitable		

Steel < 900 N/mm ²	suitable
Steel < 1100 N/mm ²	suitable
INOX < 900 N/mm ²	suitable only under restricted conditions
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
Uni	suitable
Oil	suitable
wet maximum	suitable
wet minimum	suitable
dry	suitable
Air	suitable