


**DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 2mm**

**Order data**

Order number	220317 2
GTIN	4034221140029
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**

Width across flats AF	8 mm
Flute length $L_2$	3 mm
DUO-LOCK interface	DL10
$\varnothing D_2$	9.6 mm
Corner chamfer angle	45 degrees
recommended tightening torque	20 Nm
Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup>	0.036 mm
Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup>	0.018 mm
Overhang $L_1$	3 mm
Cutter $\varnothing D$	2 mm

Corner chamfer width at 45°	0.04 mm
Overall length L	20 mm
Tolerance nominal Ø	f8
Number of cutting edges Z	4
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Helix angle	32 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 <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
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		