


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

Order data

Order number	220316 12
GTIN	4034221103154
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

Overhang L_1	9 mm
Tolerance nominal \varnothing	f8
Flute length L_2	9 mm
Feed f_z for slot milling in steel $< 900 \text{ N/mm}^2$	0.03 mm
Width across flats AF	9.5 mm
Corner chamfer angle	45 degrees
Overall length L	15 mm
Corner chamfer width at 45°	0.24 mm

Ø D ₂	11.5 mm
Cutter Ø D	12 mm
recommended tightening torque	30 Nm
Feed f _z for side milling in steel < 900 N/mm ²	0.065 mm
DUO-LOCK interface	DL12
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	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		