


DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 4mm

Order data

Order number	220317 4
GTIN	4034221140043
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

Overall length L	20 mm
Ø D ₂	9.6 mm
Cutter Ø D	4 mm
Width across flats AF	8 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.036 mm
Tolerance nominal Ø	f8
Corner chamfer angle	45 degrees
DUO-LOCK interface	DL10
Corner chamfer width at 45°	0.08 mm
Feed f _z for slot milling in steel < 900 N/mm ²	0.018 mm

recommended tightening torque	20 Nm
Flute length L_2	6 mm
Overhang L_1	6 mm
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	$0.05 \times D$ for side milling
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
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	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		