


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

Order data

Order number	220323 12
GTIN	4034221125699
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

Corner chamfer width at 45°	0.24 mm
DUO-LOCK interface	DL12
recommended tightening torque	30 Nm
Feed f_z for side milling in steel < 900 N/mm ²	0.065 mm
Corner chamfer angle	45 degrees
Width across flats AF	9.5 mm
Overhang L_1	18 mm
Ø D_2	11.5 mm
Cutter Ø D	12 mm
Tolerance nominal Ø	f8

Overall length L	24 mm
Flute length L ₂	18 mm
Number of cutting edges Z	6
Coating	AlTiN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Spacing of the cutters	unequal spacing
Helix angle	35 degrees
Direction of infeed	horizontal
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	280 m/min	P
Steel < 750 N/mm ²	suitable	220 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
INOX < 900 N/mm ²	suitable	120 m/min	M
INOX > 900 N/mm ²	suitable	90 m/min	M

Ti > 850 N/mm ²	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable only under restricted conditions	200 m/min	K
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		