


**DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 20mm**

**Order data**

Order number	220323 20
GTIN	4034221125842
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°	0.4 mm
Cutter Ø D	20 mm
Flute length L <sub>2</sub>	30 mm
recommended tightening torque	80 Nm
Ø D <sub>2</sub>	19.3 mm
Overhang L <sub>1</sub>	30 mm
Width across flats AF	16 mm
Corner chamfer angle	45 degrees
DUO-LOCK interface	DL20
Tolerance nominal Ø	f8

Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.09 mm
Overall length L	40 mm
Number of cutting edges Z	10
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	$0.05 \times D$ 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 $> 10\% \text{ Si}$	suitable only under restricted conditions	235 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	280 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	220 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	200 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	160 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	120 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	90 m/min	M

Ti > 850 N/mm <sup>2</sup>	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		