



DUO-LOCK HAIMER MILL HPC, AlTiN, Ø f9 D1: 10mm



Order data

Order number	220323 10
GTIN	4034221125606
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

recommended tightening torque	20 Nm
Tolerance nominal Ø	f8
Corner chamfer width at 45°	0.2 mm
Flute length L ₂	15 mm
Feed f _z for side milling in steel < 900 N/mm ²	0.06 mm
Overall length L	20 mm
Cutter Ø D	10 mm
Width across flats AF	8 mm
Ø D ₂	9.6 mm
DUO-LOCK interface	DL10

Overhang L_1	15 mm
Corner chamfer angle	45 degrees
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	$0.05 \times D$ 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% 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		