



DUO-LOCK HAIMER MILL 90° HPC, Ø f9 D1: 12mm



Order data

Order number	220353 12
GTIN	4034221132475
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

Number of cutting edges Z	2
Tolerance nominal Ø	f8
Cutting width a_e for milling operation	0.05×D for side milling
Overhang L_1	12 mm
recommended tightening torque	30 Nm
Feed f_z for side milling in steel < 900 N/mm ²	0.065 mm
Feed f_z for slot milling in steel < 900 N/mm ²	0.03 mm
DUO-LOCK interface	DL12
Ø D_2	11.5 mm
Width across flats AF	9,5 Nm

Chamfer mill	45 degrees
Cutter Ø D	12 mm
Overall length L	15 mm
Helix angle	20 degrees
Coating	AlTiN
Tool material	Solid carbide
Countersink tip angle	90
Standard	Manufacturer's standard
Type	N
Shank	with threaded shank
Through-coolant	no
Machining strategy	HPC
Type of product	Threaded copy milling cutter

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	160 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	35 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		