



## DUO-LOCK HAIMER MILL 90° HPC, Ø h6 D1: 12mm



### Order data

Order number	220359 12
GTIN	4034221103093
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

Tolerance nominal Ø	h6
Number of cutting edges Z	6
Ø D <sub>2</sub>	2.4 mm
DUO-LOCK interface	DL12
Overhang L <sub>1</sub>	4.8 mm
Width across flats AF	9,5 Nm
recommended tightening torque	30 mm
Chamfer mill	45 degrees
Feed f <sub>z</sub> in steel < 900 N/mm <sup>2</sup>	0.065 mm
Overall length L	15 mm

Cutter Ø D	12 mm
Coating	AlTiN
Tool material	Solid carbide
Countersink tip angle	90
Standard	Manufacturer's standard
Type	N
Direction of infeed	horizontal, oblique and vertical
Through-coolant	no
Machining strategy	HPC
Type of product	Threaded copy milling cutter

## User data

	Suitability	V <sub>c</sub>	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 <sup>2</sup>	suitable	220 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	120 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	60 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	130 m/min	K

Uni	suitable
Oil	suitable
wet maximum	suitable
wet minimum	suitable
dry	suitable
Air	suitable