

**HAIMER MILL end mill, AlTiN, Ø f9 DC: 6mm****Order data**

Order number	220287 6
GTIN	2050002068148
Item class	26X

Description**Version:**

For **general-purpose use** in steel materials and high-alloy steels, especially stainless steel. With **cylindrical core** for optimised tool stiffness when milling slots. Reliable processes guaranteed when ramping and during circular interpolation milling thanks to **special end face geometry**.

Note:

Tool holders with the SAFE-LOCK pull-out protection can be found under clamping technology. For **HB** use order **No. 220287**.

Technical description

Shank	DIN 6535 HB to h6
Feed f_z for slot milling in steel < 900 N/mm ²	0.033 mm
Corner chamfer angle	45 degrees
Cutting edge Ø D_c	6 mm
Tolerance nominal Ø	f8
Corner chamfer width at 45°	0.12 mm
Flute length L_c	13 mm
Helix angle	32 degrees
Recess Ø D_1	5.7 mm
Overall length L	58 mm
No. of teeth Z	4

Shank $\varnothing D_s$	6 mm
Feed f_z for side milling in steel $< 900 \text{ N/mm}^2$	0.039 mm
Direction of infeed	horizontal, oblique and vertical
Overhang length L_1 incl. recess	20 mm
Coating	AlTiN
Tool material	Solid carbide
Standard	DIN 6527
Type	N
Helix angle characteristic	unequal spacing
Spacing of the cutters	unequal spacing
Cutting width a_e for milling operation	$0.05 \times D$ for side milling
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Machining strategy	HPC
Colour ring	without
Type of product	End / face mill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions		
Aluminium (short chipping)	suitable only under restricted conditions		
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions		
Steel $< 500 \text{ N/mm}^2$	suitable		
Steel $< 750 \text{ N/mm}^2$	suitable		
Steel $< 900 \text{ N/mm}^2$	suitable		
Steel $< 1100 \text{ N/mm}^2$	suitable		
INOX $< 900 \text{ N/mm}^2$	suitable		

INOX > 900 N/mm ²	suitable
Ti > 850 N/mm ²	suitable only under restricted conditions
GG(G)	suitable only under restricted conditions
Uni	suitable
Oil	suitable
wet maximum	suitable
wet minimum	suitable
dry	suitable
Air	suitable