# HAIMER MILL end mill, AlTiN, ⌀ f9 DC: 5mm

## Order data

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| Order number | 220287 5 |
| GTIN | 2050002068131 |
| 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

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| Feed $f_z$ for slot milling in steel < 900 N/mm$^2$ | 0.028 mm |
| Shank ⌀ $D_s$ | 6 mm |
| Tolerance nominal ⌀ | f8 |
| No. of teeth Z | 4 |
| Corner chamfer angle | 45 degrees |
| Helix angle | 32 degrees |
| Direction of infeed | horizontal, oblique and vertical |
| Recess ⌀ $D_1$ | 4.8 mm |
| Overhang length $L_1$ incl. recess | 18 mm |
| Feed $f_z$ for side milling in steel < 900 N/mm$^2$ | 0.033 mm |
| Cutting edge ⌀ $D_C$ | 5 mm |

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|---|---|
| Flute length $L_c$ | 13 mm |
| Corner chamfer width at 45° | 0.1 mm |
| Overall length L | 58 mm |
| Shank | DIN 6535 HB to h6 |
| 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×D for side milling |
| Cutting width $a_e$ for milling operation | 0.5×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% Si | suitable only under restricted conditions | | |
| Steel < 500 N/mm² | suitable | | |
| Steel < 750 N/mm² | suitable | | |
| Steel < 900 N/mm² | suitable | | |
| Steel < 1100 N/mm² | suitable | | |
| INOX < 900 N/mm² | suitable | | |

| | |
|---|---|
| INOX > 900 N/mm² | suitable |
| Ti > 850 N/mm² | 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 |