


HAIMER MILL end mill, AlTiN, Ø f9 DC: 4mm

Order data

Order number	220291 4
GTIN	2050002068223
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:

For **HB** use order **No. 220291**.

Tool holders with the SAFE-LOCK pull-out protection can be found under clamping technology.

Technical description

Cutting edge Ø D _c	4 mm
Flute length L _c	11 mm
Corner chamfer angle	90 degrees
Overall length L	58 mm
No. of teeth Z	4
Helix angle	32 degrees
Recess Ø D ₁	3.8 mm
Tolerance nominal Ø	f8
Feed f _z for slot milling in steel < 900 N/mm ²	0.022 mm
Shank Ø D _s	6 mm
Shank	DIN 6535 HB to h6

Overhang length L_1 incl. recess	15 mm
Feed f_z for side milling in steel < 900 N/mm ²	0.026 mm
Direction of infeed	horizontal, oblique and vertical
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/mm ²	suitable		
Steel < 750 N/mm ²	suitable		
Steel < 900 N/mm ²	suitable		
Steel < 1100 N/mm ²	suitable		
INOX < 900 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