



## HAIMER MILL end mill, AlTiN, Ø f9 DC: 6mm



### Order data

Order number	220293 6
GTIN	2050002068308
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. 220293**.

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

### Technical description

Corner chamfer angle	45 degrees
Corner chamfer width at 45°	0.12 mm
Cutting edge Ø D <sub>c</sub>	6 mm
Feed f <sub>z</sub> for side milling in steel < 900 N/mm <sup>2</sup>	0.039 mm
Overhang length L <sub>1</sub> incl. recess	24 mm
Helix angle	38 degrees
Feed f <sub>z</sub> for slot milling in steel < 900 N/mm <sup>2</sup>	0.033 mm
Shank Ø D <sub>s</sub>	6 mm
Shank	DIN 6535 HB to h6
Direction of infeed	horizontal, oblique and vertical
Recess Ø D <sub>1</sub>	5.7 mm

Overall length L	62 mm
No. of teeth Z	4
Tolerance nominal $\varnothing$	f8
Flute length $L_c$	18 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×D for side milling
Cutting width $a_e$ for milling operation	0.05×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 <sup>2</sup>	suitable		
Steel < 750 N/mm <sup>2</sup>	suitable		
Steel < 900 N/mm <sup>2</sup>	suitable		
Steel < 1100 N/mm <sup>2</sup>	suitable		
INOX < 900 N/mm <sup>2</sup>	suitable		

INOX > 900 N/mm <sup>2</sup>	suitable
Ti > 850 N/mm <sup>2</sup>	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