


**HAIMER MILL solid carbide torus cutter, AlTiN, Ø f9 DC / R1: 5/0,5mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 220297 5/0,5  |
| GTIN         | 2050002068384 |
| Item class   | 26X           |

**Description**
**Version:**

For **general-purpose use** in steel materials and high-alloy steels, especially stainless steel. With **cylindrical core** for optimum 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. 220297**.

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

**Technical description**

|  |                   |
|--|-------------------|
| Feed $f_z$ for slot milling in steel < 900 N/mm <sup>2</sup> | 0.028 mm          |
| No. of teeth Z   | 4                 |
| Shank  | DIN 6535 HB to h6 |
| Cutting edge $\varnothing D_c$                               | 5 mm              |
| Overall length L   | 58 mm             |
| Corner radius $R_1$  | 0.5 mm            |
| Flute length $L_c$   | 13 mm             |
| Helix angle  | 32 degrees        |
| Shank $\varnothing D_s$                                      | 6 mm              |
| Recess $\varnothing D_1$                                     | 4.8 mm            |
| Overhang length $L_1$ incl. recess                           | 18 mm             |

|  |                                  |
|--|----------------------------------|
| Feed $f_z$ for side milling in steel < 900 N/mm <sup>2</sup> | 0.033 mm                         |
| Coating  | AlTiN                            |
| Tool material  | Solid carbide                    |
| Standard   | DIN 6527                         |
| Type   | N                                |
| Tolerance nominal $\varnothing$                              | f9                               |
| Helix angle characteristic                                   | unequal spacing                  |
| Spacing of the cutters                                       | unequal spacing                  |
| Direction of infeed  | horizontal, oblique and vertical |
| 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                              |
| Type of product  | Torus cutter                     |

## 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                                  |