


**HAIMER MILL solid carbide torus cutter, AlTiN, Ø f9 DC / R1: 8/1,5mm**

**Order data**

Order number	220297 8/1,5
GTIN	2050002068452
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**

Corner radius $R_1$	1.5 mm
No. of teeth $Z$	4
Shank	DIN 6535 HB to h6
Shank $\varnothing D_s$	8 mm
Feed $f_z$ for side milling in steel $< 900 \text{ N/mm}^2$	0.052 mm
Cutting edge $\varnothing D_c$	8 mm
Overall length $L$	64 mm
Feed $f_z$ for slot milling in steel $< 900 \text{ N/mm}^2$	0.044 mm
Flute length $L_c$	19 mm
Overhang length $L_1$ incl. recess	26 mm
Helix angle	32 degrees

Recess $\varnothing D_1$	7.6 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