

Cooling	   
Tolerance	h6
Coating	AlphaSlide Rainbow

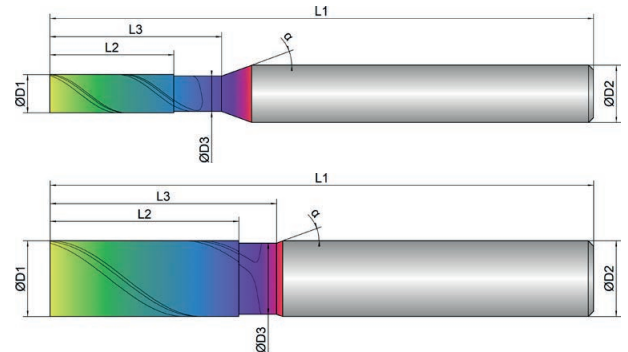
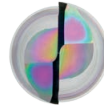
Strategy	ETC	HSC	HPC	
Application				
Features	HA	2xD		



- Defined clearance angle for ideal stabilization with high cutting depths
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume

- For roughing and finishing, up to 1.5xD full slot
- For process reliable, helical diving and immersion

- For use in high speed milling machines

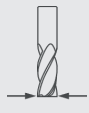
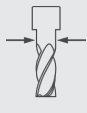
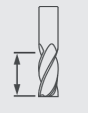
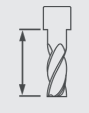
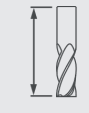
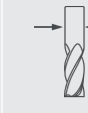


Roughing



Finishing



	D1	D3	L2	L3	L1	D2	z		α
EXN1-M01-0043	 mm Ø	 mm Ø	 mm	 mm	 mm	 mm Ø	 #	 °	 °
4	4.0	3.7	13.0	18.0	57.0	6.0	2	38	20
6	6.0	5.5	16.0	21.0	57.0	6.0	2	38	20
8	8.0	7.5	22.0	27.0	63.0	8.0	2	38	20
10	10.0	9.4	25.0	30.0	72.0	10.0	2	38	20
12	12.0	11.4	28.0	33.0	83.0	12.0	2	38	20
16	16.0	15.4	36.0	41.0	92.0	16.0	2	38	20
20	20.0	19.4	41.0	51.0	104.0	20.0	2	38	20



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			Dimension	Ø 4		Ø 6		Ø 8		Ø 10		Ø 12		Ø 16	
			Infeed in mm	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD
			Application	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD
Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
N	Vc (m/min)														
1.1	Aluminium, alloyed	<500	500	0.05	0.06	0.06	0.08	0.08	0.09	0.09	0.12	0.1	0.14	0.14	0.18
1.2	Aluminium, alloyed	<600	480	0.05	0.06	0.06	0.08	0.08	0.09	0.09	0.12	0.1	0.14	0.14	0.18
2.1-2.3	Aluminium, casted	<600	450	0.045	0.055	0.055	0.075	0.07	0.08	0.08	0.11	0.09	0.13	0.12	0.16
3.1-3.3	Cooper, alloyed	<650	200	0.04	0.05	0.05	0.07	0.06	0.07	0.07	0.1	0.09	0.13	0.12	0.16
4.1	Magnesium, alloyed	<250	500	0.05	0.06	0.06	0.08	0.08	0.09	0.09	0.12	0.1	0.14	0.14	0.18
5.1	Thermoplastic	<100	400	0.04	0.05	0.05	0.06	0.06	0.07	0.07	0.08	0.08	0.09	0.09	0.11
5.2	Duroplastic	<150	350	0.03	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.07	0.08	0.08	0.1

			Dimension	Ø 20							
			Infeed in mm	ae= 1xD	ae= 0.3xD						
			Application	ap= 1xD	ap= 2xD						
Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz							
N	Vc (m/min)										
1.1	Aluminium, alloyed	<500	500	0.18	0.22						
1.2	Aluminium, alloyed	<600	480	0.18	0.22						
2.1-2.3	Aluminium, casted	<600	450	0.16	0.2						
3.1-3.3	Cooper, alloyed	<650	200	0.16	0.2						
4.1	Magnesium, alloyed	<250	500	0.18	0.22						
5.1	Thermoplastic	<100	400	0.11	0.14						
5.2	Duroplastic	<150	350	0.1	0.13						