

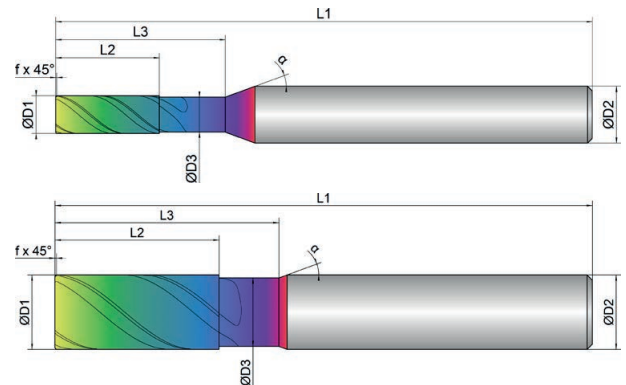
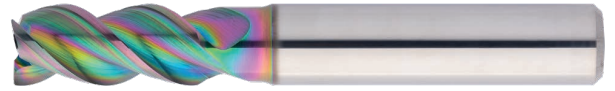
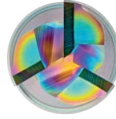
Cooling	   
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	ETC	HPC		
Application				
Features	HA	≠		



- 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 process reliable, helical diving and immersion
- For roughing and finishing, up to 2xD full slot

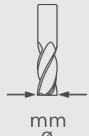
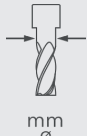
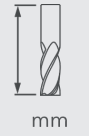


Roughing



Finishing



EXN1-M01-0103	D1  mm Ø	D3  mm Ø	L2  mm	L3  mm	L1  mm	D2  mm Ø	z  #	45° mm	 °
3	3.0	2.7	8.0	12.0	57.0	6.0	3	0.10	45
4	4.0	3.7	11.0	18.0	57.0	6.0	3	0.10	45
5	5.0	4.7	13.0	18.0	57.0	6.0	3	0.10	45
6	6.0	5.7	13.0	18.0	57.0	6.0	3	0.20	45
8	8.0	7.4	21.0	25.0	63.0	8.0	3	0.20	45
10	10.0	9.2	22.0	30.0	72.0	10.0	3	0.20	45
12	12.0	11.0	26.0	36.0	83.0	12.0	3	0.20	45
16	16.0	15.0	36.0	42.0	92.0	16.0	3	0.20	45
20	20.0	19.0	41.0	52.0	104.0	20.0	3	0.20	45



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			Strength (N/mm²)	Dimension	Ø3		Ø4		Ø5		Ø6		Ø8		Ø10			
				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		
					ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD		
					Application													
Material		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	0.04	0.05	0.05	0.06	0.055	0.07	0.06	0.08	0.08	0.1	0.09	0.12			
1.2	Aluminium, alloyed	<600	480	0.04	0.05	0.05	0.06	0.055	0.07	0.06	0.08	0.08	0.1	0.09	0.12			
2.1-2.3	Aluminium, casted	<600	450	0.035	0.045	0.045	0.055	0.05	0.065	0.055	0.075	0.075	0.09	0.08	0.11			
3.1-3.3	Cooper, alloyed	<650	200	0.03	0.04	0.04	0.05	0.045	0.06	0.05	0.07	0.07	0.085	0.075	0.1			
4.1	Magnesium, alloyed	<250	500	0.04	0.05	0.05	0.06	0.055	0.07	0.06	0.08	0.08	0.1	0.09	0.12			
5.1	Thermoplastic	<100	400	0.03	0.04	0.04	0.045	0.04	0.05	0.045	0.065	0.055	0.065	0.065	0.085			
5.2	Duroplastic	<150	350	0.025	0.035	0.03	0.035	0.035	0.04	0.035	0.055	0.045	0.055	0.055	0.075			
				Dimension	Ø12		Ø16		Ø20									
				Infeed in mm	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD								
					ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD								
					Application													
				Material		Feed (mm/Z)	fz	fz	fz	fz	fz	fz						
N				Vc (m/min)														
1.1	Aluminium, alloyed	<500	500	0.1	0.14	0.14	0.18	0.18	0.22									
1.2	Aluminium, alloyed	<600	480	0.1	0.14	0.14	0.18	0.18	0.22									
2.1-2.3	Aluminium, casted	<600	450	0.09	0.13	0.13	0.17	0.17	0.2									
3.1-3.3	Cooper, alloyed	<650	200	0.085	0.12	0.12	0.16	0.16	0.18									
4.1	Magnesium, alloyed	<250	500	0.1	0.14	0.14	0.18	0.18	0.22									
5.1	Thermoplastic	<100	400	0.075	0.11	0.11	0.13	0.13	0.17									
5.2	Duroplastic	<150	350	0.065	0.1	0.1	0.12	0.12	0.16									