Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

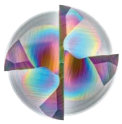
Strategy	ETC, HPC
Application	
Features	HA, ≠, 2xD

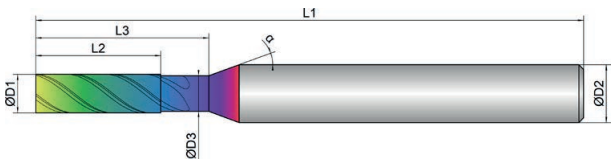
Expert

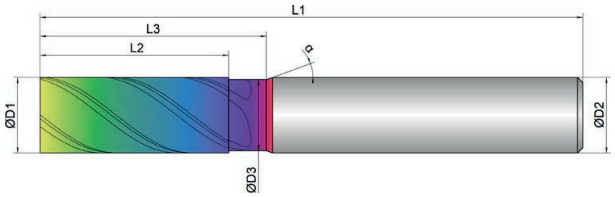
- Extra large chip chambers for ideal chip evacuation
- Unequal tooth pitch combined with variable helical pitch for smooth running
- Reinforced face with 2 cutting edges to the center

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

- Perfected for high radial depth of cutting and full slot milling







Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M01-0293	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #	°	α °
4	4.0	3.7	13.0	18.0	57.0	6.0	4	38	20
5	5.0	4.5	14.0	18.0	57.0	6.0	4	38	20
6	6.0	5.5	16.0	21.0	57.0	6.0	4	38	20
8	8.0	7.5	22.0	27.0	63.0	8.0	4	38	20
10	10.0	9.4	25.0	30.0	72.0	10.0	4	38	20
12	12.0	11.4	28.0	33.0	83.0	12.0	4	38	20
16	16.0	15.4	36.0	41.0	92.0	16.0	4	38	20
20	20.0	19.4	41.0	51.0	104.0	20.0	4	38	20

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	Material	Strength (N/mm²)	Dimension	Ø4		Ø5		Ø6		Ø8		Ø10		Ø12	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD
			Application												
			Feed (mm/Z)	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	0.045	0.065	0.05	0.07	0.07	0.09	0.09	0.11	0.1	0.14
1.2	Aluminium, alloyed	<600	480	0.04	0.05	0.045	0.65	0.05	0.07	0.07	0.09	0.09	0.11	0.1	0.14
2.1-2.3	Aluminium, casted	<600	450	0.035	0.045	0.04	0.06	0.045	0.065	0.065	0.085	0.08	0.1	0.09	0.13
3.1-3.3	Cooper, alloyed	<650	200	0.03	0.04	0.035	0.055	0.035	0.055	0.055	0.075	0.07	0.09	0.08	0.12
4.1	Magnesium, alloyed	<250	500	0.04	0.05	0.045	0.065	0.05	0.07	0.07	0.09	0.09	0.11	0.1	0.14
5.1	Thermoplastic	<100	400	0.035	0.045	0.035	0.045	0.04	0.05	0.05	0.07	0.07	0.09	0.09	0.11
5.2	Duroplastic	<150	350	0.03	0.04	0.03	0.04	0.035	0.04	0.04	0.06	0.06	0.08	0.08	0.1

	Material	Strength (N/mm²)	Dimension	Ø16		Ø20	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD
			Application				
			Feed (mm/Z)	fz	fz	fz	fz
N			Vc (m/min)				
1.1	Aluminium, alloyed	<500	500	0.12	0.16	0.15	0.2
1.2	Aluminium, alloyed	<600	480	0.12	0.16	0.15	0.2
2.1-2.3	Aluminium, casted	<600	450	0.11	0.15	0.14	0.18
3.1-3.3	Cooper, alloyed	<650	200	0.1	0.13	0.12	0.16
4.1	Magnesium, alloyed	<250	500	0.12	0.16	0.15	0.2
5.1	Thermoplastic	<100	400	0.1	0.13	0.13	0.17
5.2	Duroplastic	<150	350	0.09	0.12	0.12	0.16