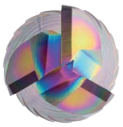
Cooling	
Tolerance	e8
Coating	AlphaSlide Rainbow

Strategy	ETC, HPC
Application	
Features	HA, 2xD

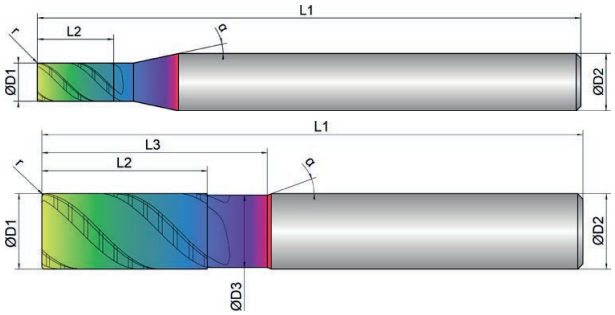
Expert

- Roughing teeth for the smallest chips in volume machining
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume



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

- Also ideally designed for trochoidal milling



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M02-0023	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	r mm	°	α °
4	4.0	0.0	8.0	0.0	57.0	6.0	3	0.10	45	12
5	5.0	0.0	9.0	0.0	57.0	6.0	3	0.20	45	12
6	6.0	5.6	13.0	19.0	57.0	6.0	3	0.20	45	20
8	8.0	7.6	19.0	25.0	63.0	8.0	3	0.20	45	20
10	10.0	9.6	22.0	30.0	72.0	10.0	3	0.32	45	20
12	12.0	11.4	26.0	36.0	83.0	12.0	3	0.32	45	20
16	16.0	15.4	31.0	42.0	92.0	16.0	3	0.32	45	20
20	20.0	19.4	41.0	52.0	104.0	20.0	3	0.50	45	20

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	Material	Strength (N/mm²)	Dimension	Ø4		Ø5		Ø6		Ø8		Ø10		Ø12	
			Infeed in mm	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD	ae= 1xD ap= 2xD	ae= 0.6xD 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	0.035	0.05	0.05	0.07	0.07	0.09	0.09	0.11	0.11	0.13	0.13	0.15
1.2	Aluminium, alloyed	<600	480	0.035	0.05	0.05	0.07	0.07	0.09	0.09	0.11	0.11	0.13	0.13	0.15
2.1-2.3	Aluminium, casted	<600	450	0.03	0.045	0.045	0.065	0.065	0.085	0.085	0.1	0.1	0.12	0.12	0.14
3.1-3.3	Cooper, alloyed	<650	200	0.025	0.04	0.04	0.06	0.06	0.08	0.08	0.095	0.09	0.11	0.11	0.13
4.1	Magnesium, alloyed	<250	500	0.035	0.05	0.05	0.07	0.07	0.09	0.09	0.11	0.11	0.13	0.13	0.15
5.1	Thermoplastic	<100	*350*	*0.03*	*0.045*	*0.035*	*0.05*	*0.05*	*0.07*	*0.06*	*0.07*	*0.07*	*0.09*	*0.07*	*0.11*
5.2	Duroplastic	<150	*300*	*0.025*	*0.04*	*0.03*	*0.045*	*0.045*	*0.06*	*0.05*	*0.06*	*0.06*	*0.08*	*0.06*	*0.1*

	Material	Strength (N/mm²)	Dimension	Ø16		Ø20	
			Infeed in mm	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD	ae= 1xD ap= 2xD	ae= 0.6xD ap= 2xD
			Application				
			Feed (mm/Z)	fz	fz	fz	fz
N			Vc (m/min)				
1.1	Aluminium, alloyed	<500	500	0.14	0.16	0.18	0.22
1.2	Aluminium, alloyed	<600	480	0.14	0.16	0.18	0.22
2.1-2.3	Aluminium, casted	<600	450	0.13	0.15	0.16	0.2
3.1-3.3	Cooper, alloyed	<650	200	0.12	0.14	0.14	0.18
4.1	Magnesium, alloyed	<250	500	0.14	0.16	0.18	0.22
5.1	Thermoplastic	<100	*350*	*0.11*	*0.14*	*0.14*	*0.18*
5.2	Duroplastic	<150	*300*	*0.1*	*0.13*	*0.13*	*0.17*

NOTE | The values marked in turquoise are side applications!