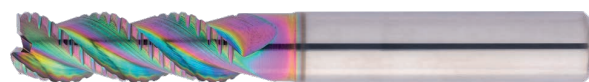
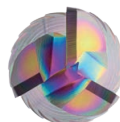


Cooling	   
Tolerance	e8
Coating	AlphaSlide Rainbow

Strategy	ETC	HPC			
Application					
Features	HA	≠		3xD	

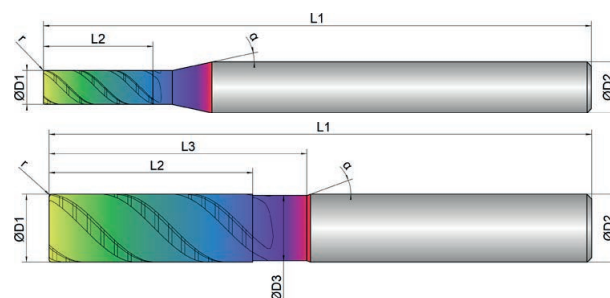


- Roughing teeth for the smallest chips in volume machining
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume



- For roughing, up to 3xD full slot
- For process reliable, helical diving and immersion

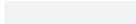
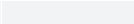
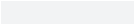
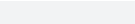
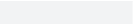
- Also ideally designed for trochoidal milling

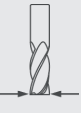
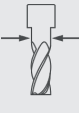
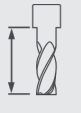
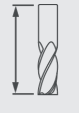
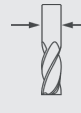


Roughing

				
inappropriate				optimal

Finishing

				
inappropriate				optimal

EXN1-M02-0053	D1  mm ø	D3  mm ø	L2  mm	L3  mm	L1  mm	D2  mm ø	z  #	r  mm	 °	α  °
4	4.0	0.0	13.0	0.0	65.0	6.0	3	0.10	45	12
5	5.0	0.0	16.0	0.0	65.0	6.0	3	0.20	45	12
6	6.0	5.6	18.0	24.0	65.0	6.0	3	0.20	45	20
8	8.0	7.6	24.0	30.0	70.0	8.0	3	0.20	45	20
10	10.0	9.6	30.0	38.0	80.0	10.0	3	0.32	45	20
12	12.0	11.4	36.0	46.0	93.0	12.0	3	0.32	45	20
16	16.0	15.4	48.0	58.0	110.0	16.0	3	0.32	45	20
20	20.0	19.4	60.0	74.0	125.0	20.0	3	0.50	45	20



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			Dimension	Ø 4		Ø 5		Ø 6		Ø 8		Ø 10		Ø 12	
			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= 2xD	ap= 3xD	ap= 2xD	ap= 3xD	ap= 2xD	ap= 3xD	ap= 2xD	ap= 3xD	ap= 2xD	ap= 3xD	ap= 2xD	ap= 3xD
			Application												
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	0.03	0.04	0.04	0.06	0.06	0.08	0.08	0.1	0.1	0.12	0.12	0.14
1.2	Aluminium, alloyed	<600	480	0.03	0.04	0.04	0.06	0.06	0.08	0.08	0.1	0.1	0.12	0.12	0.14
2.1-2.3	Aluminium, casted	<600	450	0.025	0.035	0.035	0.055	0.055	0.07	0.07	0.09	0.09	0.11	0.11	0.13
3.1-3.3	Cooper, alloyed	<650	200	0.015	0.025	0.025	0.045	0.045	0.06	0.06	0.08	0.08	0.1	0.1	0.12
4.1	Magnesium, alloyed	<250	500	0.03	0.04	0.04	0.06	0.06	0.08	0.08	0.1	0.1	0.12	0.12	0.14
5.1	Thermoplastic	<100	350	0.025	0.035	0.03	0.045	0.04	0.06	0.05	0.06	0.06	0.08	0.06	0.1
5.2	Duroplastic	<150	300	0.02	0.03	0.025	0.04	0.035	0.055	0.04	0.05	0.05	0.07	0.05	0.09

			Dimension	Ø 16		Ø 20					
			Infeed in mm	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD				
				ap= 2xD	ap= 3xD	ap= 2xD	ap= 3xD				
			Application								
Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz					
N	Vc (m/min)										
1.1	Aluminium, alloyed	<500	500	0.13	0.15	0.16	0.2				
1.2	Aluminium, alloyed	<600	480	0.13	0.15	0.16	0.2				
2.1-2.3	Aluminium, casted	<600	450	0.12	0.14	0.14	0.18				
3.1-3.3	Cooper, alloyed	<650	200	0.11	0.13	0.13	0.16				
4.1	Magnesium, alloyed	<250	500	0.13	0.15	0.16	0.2				
5.1	Thermoplastic	<100	350	0.1	0.13	0.13	0.17				
5.2	Duroplastic	<150	300	0.09	0.12	0.12	0.16				

NOTE | The values marked in turquoise are side applications!