

Cooling	   
Tolerance	h6
Coating	AlphaSlide Rainbow

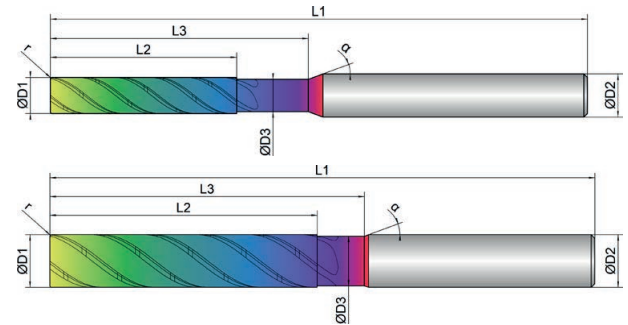
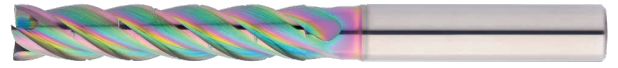
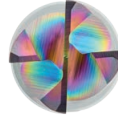
Strategy	ETC
Application	  
Features	HA   5xD  



- Chip breaker for short, defined chip length
- Unequal tooth pitch combined with variable helical pitch for smooth running
- Reinforced face with 2 cutting edges to the center

- For roughing and finishing under ETC conditions
- For process reliable, helical immersion

- Ideal chip evacuation, even with high radial depth of cutting



Roughing



Finishing



	D1	D3	L2	L3	L1	D2	z	r		α
EXN1-M03-0053	 mm Ø	 mm Ø	 mm	 mm	 mm	 mm Ø	 #	 mm	 °	 °
5	5.0	4.5	26.0	36.0	75.0	6.0	4	0.15	38	20
6	6.0	5.5	31.0	36.0	75.0	6.0	4	0.15	38	20
8	8.0	7.5	41.0	48.0	90.0	8.0	4	0.20	38	20
10	10.0	9.5	51.0	60.0	104.0	10.0	4	0.20	38	20
12	12.0	11.0	61.0	72.0	120.0	12.0	4	0.20	38	20
16	16.0	15.0	81.0	96.0	150.0	16.0	4	0.30	38	20
20	20.0	19.0	102.0	120.0	175.0	20.0	4	0.30	38	20



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			Dimension	Ø5	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20			
			Infeed in mm	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max			
			Application										
			Strength (N/mm²)										
			Feed (mm/Z)	fz	fz	fz	fz						
1.1	Aluminium, alloyed	<500	500	0.035	0.05	0.065	0.08	0.095	0.13	0.16			
1.2	Aluminium, alloyed	<600	480	0.035	0.05	0.065	0.08	0.095	0.13	0.16			
2.1-2.3	Aluminium, casted	<600	460	0.03	0.045	0.06	0.07	0.085	0.12	0.15			
3.1-3.3	Cooper, alloyed	<650	200	0.02	0.04	0.05	0.06	0.075	0.11	0.14			
4.1	Magnesium, alloyed	<250	500	0.035	0.045	0.065	0.08	0.095	0.13	0.16			
5.1	Thermoplastic	<100											
5.2	Duroplastic	<150											
NOTE From Ø10 we recommend the use of HB shank and side lock arbor (EXN1-M03-0054).													