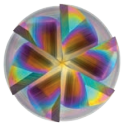
Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	HPC
Application	
Features	HA, ≠, 3xD

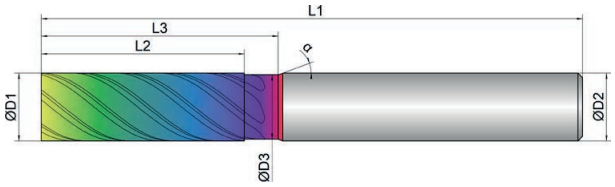
Expert

- Ultra-sharp and lapped cutting edges
- Special chip chambers designed for the evacuation of extra long and fine chips
- Face-Finish-bevel for smooth workpiece surfaces



- For excellent surfaces and maximum dimensional accuracy

- 6 cutting edges for highest feed rates



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M04-0033	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	°	α °
6	6.0	5.8	18.0	25.0	65.0	6.0	6	39	20
8	8.0	7.8	24.0	30.0	70.0	8.0	6	39	20
10	10.0	9.5	30.0	35.0	80.0	10.0	6	39	20
12	12.0	11.5	36.0	45.0	93.0	12.0	6	39	20
16	16.0	15.5	48.0	55.0	110.0	16.0	6	39	20
20	20.0	19.5	60.0	70.0	125.0	20.0	6	39	20

Download Catalog Pages (PDF)

	Material	Strength (N/mm²)	Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
			Infeed in mm	ae= 0.05xD ap= L2 max	ae= 0.05xD ap= L2 max	ae= 0.05xD ap= L2 max	ae= 0.05xD ap= L2 max	ae= 0.05xD ap= L2 max	ae= 0.05xD ap= L2 max
			Application						
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz
N			Vc (m/min)						
1.1	Aluminium, alloyed	<500	380	0.03	0.032	0.034	0.036	0.038	0.04
1.2	Aluminium, alloyed	<600	360	0.03	0.032	0.034	0.036	0.038	0.04
2.1-2.3	Aluminium, casted	<600	320	0.025	0.027	0.029	0.031	0.033	0.035
3.1-3.3	Cooper, alloyed	<650	160	0.02	0.022	0.024	0.026	0.028	0.03
4.1	Magnesium, alloyed	<250	350	0.03	0.032	0.034	0.036	0.038	0.04
5.1	Thermoplastic	<100	300	0.025	0.027	0.029	0.031	0.033	0.035
5.2	Duroplastic	<150	260	0.02	0.022	0.024	0.026	0.028	0.03

NOTE | To achieve high surface quality, use ae = 0.2 mm for Ø 6 – 10; ae = 0.3mm for Ø 12 – 20.

STILL CAN'T FIND A SUITABLE MILLING CUTTER?

No problem – simply customize an existing tool. Using our configurator for special milling cutters, you can customize existing tools to your needs in an instant or create your own tools based on predefined types.

WE WILL RESPOND TO ALL REQUESTS SUBMITTED VIA THE CONFIGURATOR WITHIN ONE WORKING DAY AT THE LATEST