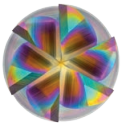
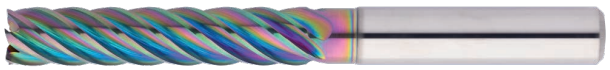
Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	HPC
Application	
Features	HA, ≠, 5xD

Expert

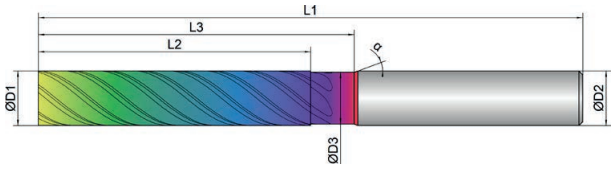
- Ultra-sharp and lapped cutting edges
- Special chip chambers designed for the evacuation of extra long and fine chips
- Face-Finish-bevel for smooth workpiece surfaces





- For excellent surfaces and maximum dimensional accuracy

- 6 cutting edges for highest feed rates



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M04-0053	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #		α °
6	6.0	5.8	30.0	38.0	75.0	6.0	6	39	20
8	8.0	7.8	40.0	48.0	80.0	8.0	6	39	20
10	10.0	9.5	50.0	58.0	100.0	10.0	6	39	20
12	12.0	11.5	60.0	68.0	120.0	12.0	6	39	20
16	16.0	15.5	80.0	88.0	134.0	16.0	6	39	20
20	20.0	19.5	100.0	108.0	175.0	20.0	6	39	20

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	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	0.026	0.028	0.03	0.032	0.034	0.036
1.2	Aluminium, alloyed	<600	360	0.026	0.028	0.03	0.032	0.034	0.036
2.1-2.3	Aluminium, casted	<600	320	0.021	0.023	0.025	0.027	0.029	0.031
3.1-3.3	Cooper, alloyed	<650	160	0.016	0.018	0.02	0.022	0.024	0.026
4.1	Magnesium, alloyed	<250	350	0.026	0.028	0.03	0.032	0.034	0.036
5.1	Thermoplastic	<100	300	0.021	0.023	0.025	0.027	0.029	0.031
5.2	Duroplastic	<150	260	0.016	0.018	0.02	0.022	0.024	0.026

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