Cooling	
Tolerance	h10
Coating	AlphaSlide Rainbow

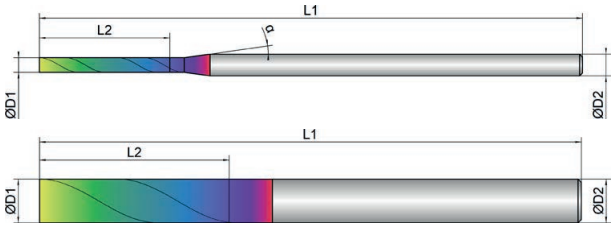
Strategy	HSC, HPC
Application	
Features	HA

Expert

- Defined clearance angle for ideal stabilization with high cutting depths
- Special helical pitch for smooth running and soft cut
- Balanced for maximum smoothness

- For roughing and finishing, up to 1.5xD full slot
- For process reliable, helical diving and immersion

- For use in high speed milling machines
- Long version with extra long cutting length



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M05-0053	D1 mm ø	L2 mm	L1 mm	D2 mm ø	z #	°	α °
1	1.0	8.0	75.0	3.0	1	30	8
1,5	1.5	12.0	75.0	3.0	1	30	8
2	2.0	18.0	75.0	3.0	1	30	8
3	3.0	22.0	75.0	3.0	1	30	0
4	4.0	25.0	75.0	4.0	1	30	0
5	5.0	25.0	75.0	5.0	1	30	0
6	6.0	30.0	100.0	6.0	1	30	0
8	8.0	35.0	100.0	8.0	1	30	0
10	10.0	40.0	100.0	10.0	1	30	0
12	12.0	45.0	120.0	12.0	1	30	0

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	Material	Strength (N/mm²)	Dimension	Ø1		Ø1.5		Ø2		Ø3		Ø4		Ø5	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD
			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	450	0.008	0.012	0.008	0.012	0.015	0.02	0.02	0.025	0.025	0.03	0.03	0.038
1.2	Aluminium, alloyed	<600	425	0.008	0.012	0.008	0.012	0.015	0.02	0.02	0.025	0.025	0.03	0.03	0.038
2.1-2.3	Aluminium, casted	<600	400	0.006	0.01	0.006	0.01	0.01	0.015	0.015	0.02	0.02	0.025	0.025	0.033
3.1-3.3	Cooper, alloyed	<650	170	0.004	0.008	0.004	0.008	0.008	0.01	0.01	0.015	0.015	0.02	0.02	0.028
4.1	Magnesium, alloyed	<250	450	0.008	0.012	0.008	0.012	0.015	0.02	0.02	0.025	0.025	0.03	0.03	0.038
5.1	Thermoplastic	<100	350	0.006	0.01	0.006	0.01	0.01	0.015	0.015	0.02	0.02	0.025	0.025	0.033
5.2	Duroplastic	<150	300	0.004	0.008	0.004	0.008	0.008	0.01	0.01	0.015	0.015	0.02	0.02	0.028

	Material	Strength (N/mm²)	Dimension	Ø6		Ø8		Ø10		Ø12	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD
			Application								
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz
N			Vc (m/min)								
1.1	Aluminium, alloyed	<500	450	0.038	0.048	0.043	0.053	0.05	0.06	0.065	0.09
1.2	Aluminium, alloyed	<600	425	0.038	0.048	0.043	0.053	0.05	0.06	0.065	0.09
2.1-2.3	Aluminium, casted	<600	400	0.033	0.043	0.038	0.048	0.045	0.055	0.06	0.08
3.1-3.3	Cooper, alloyed	<650	170	0.028	0.038	0.033	0.043	0.04	0.05	0.055	0.07
4.1	Magnesium, alloyed	<250	450	0.038	0.048	0.043	0.053	0.05	0.06	0.065	0.09
5.1	Thermoplastic	<100	350	0.033	0.043	0.038	0.048	0.045	0.055	0.06	0.08
5.2	Duroplastic	<150	300	0.028	0.038	0.033	0.043	0.04	0.05	0.055	0.07