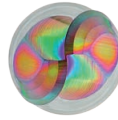


Cooling	   
Tolerance	d04
Coating	AlphaSlide Rainbow

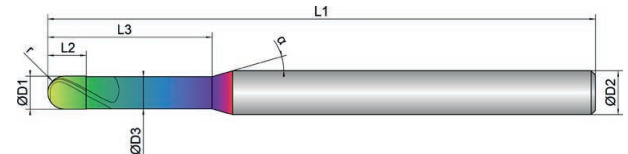
Strategy	HSC
Application	  
Features	HA 



- Optimized face geometry for excellent surfaces and highest dimensional accuracy
- Defined microbevel for support and stabilization
- Polished chip space for ideal chip evacuation



- Tolerance D1: -0.001/-0.006 mm
- Tolerance D3: 0/-0.02 mm
- Radius tolerance r: 0/-0.003 mm (measured from 0-90°)

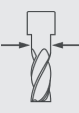
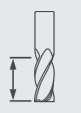
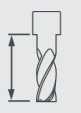
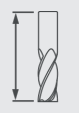
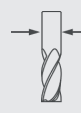


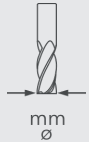
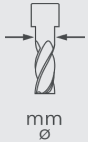
Roughing



Finishing



	D1	D3	L2	L3	L1	D2	z	r		α
EXN1-M17-0013										
0,5X10	0.5	0.47	0.4	10.0	50.0	4.0	2	0.25	30	16
0,6X10	0.6	0.57	0.5	10.0	50.0	4.0	2	0.30	30	16
0,8X10	0.8	0.77	0.6	10.0	50.0	4.0	2	0.40	30	16
0,8X12	0.8	0.77	0.6	12.0	50.0	4.0	2	0.40	30	16
1X15	1.0	0.96	0.8	15.0	50.0	4.0	2	0.50	30	16
1X20	1.0	0.96	0.8	20.0	60.0	4.0	2	0.50	30	16
1X25	1.0	0.96	0.8	25.0	60.0	4.0	2	0.50	30	16
1X30	1.0	0.96	0.8	30.0	70.0	4.0	2	0.50	30	16
1,2X15	1.2	1.16	1.0	15.0	54.0	4.0	2	0.60	30	16
1,5X15	1.5	1.44	1.2	15.0	50.0	4.0	2	0.75	30	16
1,5X20	1.5	1.44	1.2	20.0	60.0	4.0	2	0.75	30	16
1,5X25	1.5	1.44	1.2	25.0	60.0	4.0	2	0.75	30	16
1,5X30	1.5	1.44	1.2	30.0	70.0	4.0	2	0.75	30	16
1,8X15	1.8	1.74	1.4	15.0	50.0	4.0	2	0.90	30	16

EXN1-M17-0013	 mm ø	 mm ø	 mm	 mm	 mm	 mm ø	 #	 mm	 °	 °
1,8X20	1.8	1.74	1.4	20.0	54.0	4.0	2	0.90	30	16
2X12	2.0	1.94	1.6	12.0	50.0	4.0	2	1.00	30	16
2X15	2.0	1.94	1.6	15.0	50.0	4.0	2	1.00	30	16
2X20	2.0	1.94	1.6	20.0	60.0	4.0	2	1.00	30	16
2X25	2.0	1.94	1.6	25.0	60.0	4.0	2	1.00	30	16
2X30	2.0	1.94	1.6	30.0	70.0	4.0	2	1.00	30	16
2X35	2.0	1.94	1.6	35.0	80.0	4.0	2	1.00	30	16
2X40	2.0	1.94	1.6	40.0	80.0	4.0	2	1.00	30	16
2,5X15	2.5	2.41	2.0	15.0	50.0	4.0	2	1.25	30	16
2,5X20	2.5	2.41	2.0	20.0	54.0	4.0	2	1.25	30	16
2,5X25	2.5	2.41	2.0	25.0	60.0	4.0	2	1.25	30	16
2,5X30	2.5	2.41	2.0	30.0	70.0	4.0	2	1.25	30	16
3X15	3.0	2.92	3.5	15.0	50.0	4.0	2	1.50	30	16
3X20	3.0	2.92	3.5	20.0	54.0	4.0	2	1.50	30	16
3X25	3.0	2.92	3.5	25.0	60.0	4.0	2	1.50	30	16
3X30	3.0	2.92	3.5	30.0	70.0	4.0	2	1.50	30	16
3X35	3.0	2.92	3.5	35.0	70.0	4.0	2	1.50	30	16
3X40	3.0	2.92	3.5	40.0	80.0	4.0	2	1.50	30	16
3X45	3.0	2.92	3.5	45.0	80.0	4.0	2	1.50	30	16



Download Catalog
Pages (PDF)

			Dimension	Ø 0.5x10	Ø 0.6 10	Ø 0.8x10	Ø 0.8x12	Ø 1x15	Ø 1x30	Ø 1.2x15	Ø 1.5x15	Ø 1.5x30	Ø 1.8x15
			Infeed in mm	ae=0.01xD ap=0.01xD	ae=0.015xD ap=0.015xD	ae=0.035xD ap=0.035xD	ae=0.02xD ap=0.02xD	ae=0.02xD ap=0.02xD	ae=0.01xD ap=0.01xD	ae=0.035xD ap=0.035xD	ae=0.05xD ap=0.05xD	ae=0.01xD ap=0.01xD	ae=0.07xD ap=0.07xD
			Application										
Material	Strength (N/mm²)	Feed (mm/Z)	fz										
N			Vc (m/min)										
1.1	Aluminium, alloyed	<500	500	0.012	0.017	0.017	0.017	0.028	0.017	0.028	0.03	0.025	0.035
1.2	Aluminium, alloyed	<600	480	0.012	0.017	0.017	0.017	0.028	0.017	0.028	0.03	0.025	0.035
2.1-2.3	Aluminium, casted	<600	450	0.011	0.016	0.016	0.016	0.026	0.016	0.026	0.027	0.022	0.032
3.1-3.3	Cooper, alloyed	<650	220	0.01	0.015	0.015	0.015	0.024	0.015	0.024	0.024	0.019	0.029
4.1	Magnesium, alloyed	<250	500	0.012	0.017	0.017	0.017	0.028	0.017	0.028	0.03	0.025	0.035
5.1	Thermoplastic	<100	400	0.011	0.016	0.016	0.016	0.026	0.016	0.026	0.027	0.022	0.032
5.2	Duroplastic	<150	350	0.01	0.015	0.015	0.015	0.024	0.015	0.024	0.024	0.019	0.029

			Dimension	Ø 1.8x20	Ø 2x12	Ø 2x40	Ø 2.5x15	Ø 2.5x30	Ø 3x15	Ø 3x45			
			Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.09xD ap=0.09xD	ae=0.01xD ap=0.01xD	ae=0.09xD ap=0.09xD	ae=0.035xD ap=0.035xD	ae=0.09xD ap=0.09xD	ae=0.02xD ap=0.02xD			
			Application										
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz			
N			Vc (m/min)										
1.1	Aluminium, alloyed	<500	500	0.03	0.035	0.025	0.035	0.03	0.04	0.03			
1.2	Aluminium, alloyed	<600	480	0.03	0.035	0.025	0.035	0.03	0.04	0.03			
2.1-2.3	Aluminium, casted	<600	450	0.027	0.032	0.022	0.032	0.027	0.035	0.025			
3.1-3.3	Cooper, alloyed	<650	220	0.024	0.029	0.019	0.029	0.024	0.03	0.02			
4.1	Magnesium, alloyed	<250	500	0.03	0.035	0.025	0.035	0.03	0.04	0.03			
5.1	Thermoplastic	<100	400	0.027	0.032	0.022	0.032	0.027	0.035	0.025			
5.2	Duroplastic	<150	350	0.024	0.029	0.019	0.029	0.024	0.03	0.02			

NOTE | Values in the table are the shortest and the longest overhang length (L3) of each dimension; please calculate fz, ap and ae depending on the given values.



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

