Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

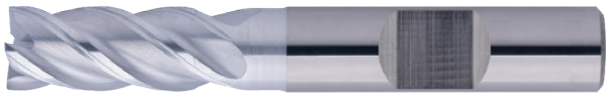
Strategy	ETC, HPC
Application	
Features	HB

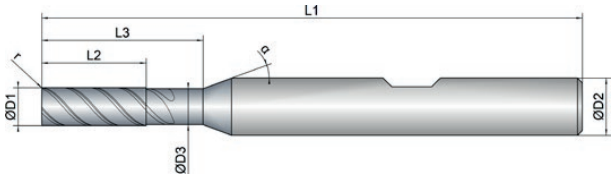
Expert

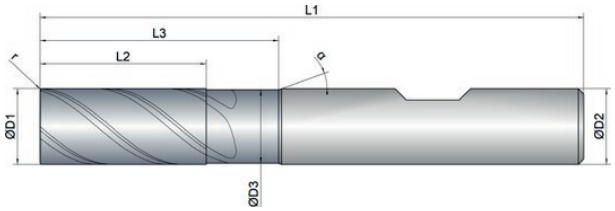
- Unequal tooth pitch combined with variable helical pitch for smooth running
- Reinforced cutting edge with corner protection radius
- Enlarged chip chambers for flushing with cooling lubricant

- Designed for maximum removal rate when milling with high radial depth of cut and in the full slot up to 1.5xD
- For process reliable ramping, helical immersion and diving (drilling) up to 1xD

- Unleashes its full performance potential when milling with cooling lubricant







Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M01-0184	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	r mm	°	α °
3	3.0	2.8	8.0	13.0	57.0	6.0	4	0.10	40	20
4	4.0	3.8	11.0	17.0	57.0	6.0	4	0.10	40	20
5	5.0	4.8	13.0	20.0	57.0	6.0	4	0.20	40	20
6	6.0	5.8	13.0	20.0	57.0	6.0	4	0.20	40	20
8	8.0	7.7	19.0	25.0	63.0	8.0	4	0.20	40	20
10	10.0	9.7	22.0	32.0	72.0	10.0	4	0.20	40	20
12	12.0	11.6	26.0	38.0	83.0	12.0	4	0.20	40	20
16	16.0	15.5	32.0	44.0	92.0	16.0	4	0.30	40	20
20	20.0	19.5	41.0	54.0	104.0	20.0	4	0.30	40	20

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	Material	Strength (N/mm²)	Dimension	Ø3		Ø4		Ø5		Ø6		Ø8		Ø10	
			Infeed in mm	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD
			Application												
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
P			**Vc (m/min)**												
1.1	Steel, unalloyed	<500	240	0.025	0.03	0.025	0.03	0.035	0.04	0.045	0.05	0.055	0.065	0.06	0.075
1.2-1.5	Steel, unalloyed	<1100	200	0.02	0.025	0.02	0.025	0.03	0.035	0.04	0.045	0.05	0.06	0.055	0.07
2.1-2.2	Steel, low-alloyed	<950	190	0.02	0.025	0.02	0.025	0.03	0.035	0.04	0.045	0.05	0.06	0.055	0.07
2.3-2.4	Steel, low-alloyed	<1300	160	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065
3.1-3.2	Steel, high-alloyed	<1100	180	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065
3.3	Steel, high-alloyed	<1400	150	0.012	0.018	0.012	0.018	0.022	0.028	0.032	0.038	0.042	0.052	0.045	0.06
K			**Vc (m/min)**												
1.1-1.2	Grey cast iron	<1000	220	0.02	0.025	0.02	0.025	0.03	0.035	0.04	0.045	0.05	0.06	0.055	0.07
2.1-2.2	Modular cast iron	<850	180	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065
3.1-3.2	Malleable cast iron	<800	160	0.015	0.02	0.015	0.02	0.025	0.03	0.035	0.04	0.045	0.055	0.05	0.065
M			**Vc (m/min)**												
1.1	Inox, ferritic/martensitic	<850	90		0.025		0.025		0.035		0.045		0.06		0.07
2.1	Inox, austenitic	<650	75		0.02		0.02		0.03		0.04		0.055		0.065
2.2	Inox, austenitic	<750	70		0.018		0.018		0.028		0.038		0.052		0.06
3.1	Duplex steel	<1100													

	Material	Strength (N/mm²)	Dimension	Ø12		Ø16		Ø20	
			Infeed in mm	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1.5xD	ae= 0.3xD ap= 2xD
			Application						
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz
P			**Vc (m/min)**						
1.1	Steel, unalloyed	<500	240	0.065	0.085	0.08	0.1	0.1	0.12
1.2-1.5	Steel, unalloyed	<1100	200	0.06	0.08	0.07	0.09	0.09	0.11
2.1-2.2	Steel, low-alloyed	<950	190	0.06	0.08	0.07	0.09	0.09	0.11
2.3-2.4	Steel, low-alloyed	<1300	160	0.055	0.075	0.06	0.08	0.08	0.1
3.1-3.2	Steel, high-alloyed	<1100	180	0.055	0.075	0.06	0.08	0.08	0.1
3.3	Steel, high-alloyed	<1400	150	0.05	0.07	0.055	0.075	0.075	0.09
K			**Vc (m/min)**						
1.1-1.2	Grey cast iron	<1000	220	0.06	0.08	0.08	0.09	0.09	0.11
2.1-2.2	Modular cast iron	<850	180	0.055	0.075	0.07	0.08	0.08	0.1
3.1-3.2	Malleable cast iron	<800	160	0.055	0.075	0.07	0.08	0.08	0.1
M			**Vc (m/min)**						
1.1	Inox, ferritic/martensitic	<850	90		0.08		0.085		0.11
2.1	Inox, austenitic	<650	75		0.075		0.08		0.1
2.2	Inox, austenitic	<750	70		0.07		0.075		0.09
3.1	Duplex steel	<1100							

NOTE | The values marked in turquoise are side applications!