

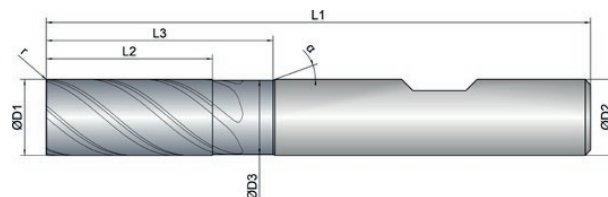
|           |                                                                                                                                                                                                                                                                                                                                         |
|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Cooling   |     |
| Tolerance | e8                                                                                                                                                                                                                                                                                                                                      |
| Coating   | AlphaFerro Platin X                                                                                                                                                                                                                                                                                                                     |

|             |                                                                                    |                                                                                     |                                                                                     |                                                                                     |
|-------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| Strategy    | ETC                                                                                | HPC                                                                                 |                                                                                     |                                                                                     |
| Application |  |  |  |                                                                                     |
| Features    | HB                                                                                 | ≠                                                                                   |  |  |



- Unequal tooth pitch combined with variable helical pitch for smooth running
- Defined cutting edge geometry for stabilization at high infeeds
- Reinforced tool core for high breakage resistance

- For roughing and finishing

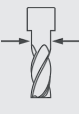
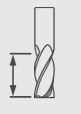
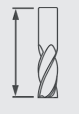
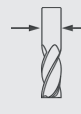


### Roughing



### Finishing



| EXPK1-M01-0224 | D1<br><br>mm<br>ø | D3<br><br>mm<br>ø | L2<br><br>mm | L3<br><br>mm | L1<br><br>mm | D2<br><br>mm<br>ø | z<br><br># | r<br><br>mm | <br>° | α<br><br>° |
|----------------|------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|
| 6              | 6.0                                                                                                  | 5.8                                                                                                  | 13.0                                                                                            | 19.0                                                                                            | 57.0                                                                                            | 6.0                                                                                                  | 5                                                                                               | 0.15                                                                                             | 40                                                                                         | 20                                                                                              |
| 8              | 8.0                                                                                                  | 7.8                                                                                                  | 19.0                                                                                            | 25.0                                                                                            | 63.0                                                                                            | 8.0                                                                                                  | 5                                                                                               | 0.20                                                                                             | 40                                                                                         | 20                                                                                              |
| 10             | 10.0                                                                                                 | 9.8                                                                                                  | 22.0                                                                                            | 30.0                                                                                            | 72.0                                                                                            | 10.0                                                                                                 | 5                                                                                               | 0.20                                                                                             | 40                                                                                         | 20                                                                                              |
| 12             | 12.0                                                                                                 | 11.8                                                                                                 | 26.0                                                                                            | 36.0                                                                                            | 83.0                                                                                            | 12.0                                                                                                 | 5                                                                                               | 0.20                                                                                             | 40                                                                                         | 20                                                                                              |
| 16             | 16.0                                                                                                 | 15.8                                                                                                 | 32.0                                                                                            | 42.0                                                                                            | 92.0                                                                                            | 16.0                                                                                                 | 5                                                                                               | 0.30                                                                                             | 40                                                                                         | 20                                                                                              |
| 20             | 20.0                                                                                                 | 19.8                                                                                                 | 41.0                                                                                            | 52.0                                                                                            | 104.0                                                                                           | 20.0                                                                                                 | 5                                                                                               | 0.30                                                                                             | 40                                                                                         | 20                                                                                              |



Download Catalog  
Pages (PDF)

|                                                                                                                                      |                            |       |              |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |    |    |  |  |  |  |
|--------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------|--------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|----|----|--|--|--|--|
| <div></div> <div>Download Catalog Pages (PDF)</div> |                            |       | Dimension    | Ø6                                                                                | Ø8                                                                                | Ø10                                                                               | Ø12                                                                               | Ø16                                                                               | Ø20                                                                                |    |    |  |  |  |  |
|                                                                                                                                      |                            |       | Infeed in mm | ae= 0.3xD<br>ap= 2xD                                                              | ae= 0.3xD<br>ap= 2xD                                                              | ae= 0.3xD<br>ap= 2xD                                                              | ae= 0.3xD<br>ap= 2xD                                                              | ae= 0.3xD<br>ap= 2xD                                                              | ae= 0.3xD<br>ap= 2xD                                                               |    |    |  |  |  |  |
|                                                                                                                                      |                            |       | Application  |  |  |  |  |  |  |    |    |  |  |  |  |
|                                                                                                                                      |                            |       | Material     | Strength (N/mm²)                                                                  | Feed (mm/Z)                                                                       | fz                                                                                | fz                                                                                | fz                                                                                | fz                                                                                 | fz | fz |  |  |  |  |
| P                                                                                                                                    |                            |       | Vc (m/min)   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |    |    |  |  |  |  |
| 1.1                                                                                                                                  | Steel, unalloyed           | <500  | 240          | 0.045                                                                             | 0.06                                                                              | 0.07                                                                              | 0.08                                                                              | 0.09                                                                              | 0.11                                                                               |    |    |  |  |  |  |
| 1.2-1.5                                                                                                                              | Steel, unalloyed           | <1100 | 200          | 0.04                                                                              | 0.055                                                                             | 0.065                                                                             | 0.075                                                                             | 0.085                                                                             | 0.1                                                                                |    |    |  |  |  |  |
| 2.1-2.2                                                                                                                              | Steel, low-alloyed         | <950  | 190          | 0.04                                                                              | 0.055                                                                             | 0.065                                                                             | 0.075                                                                             | 0.085                                                                             | 0.1                                                                                |    |    |  |  |  |  |
| 2.3-2.4                                                                                                                              | Steel, low-alloyed         | <1300 | 160          | 0.035                                                                             | 0.05                                                                              | 0.06                                                                              | 0.07                                                                              | 0.08                                                                              | 0.09                                                                               |    |    |  |  |  |  |
| 3.1-3.2                                                                                                                              | Steel, high-alloyed        | <1100 | 180          | 0.035                                                                             | 0.05                                                                              | 0.06                                                                              | 0.07                                                                              | 0.08                                                                              | 0.09                                                                               |    |    |  |  |  |  |
| 3.3                                                                                                                                  | Steel, high-alloyed        | <1400 | 150          | 0.032                                                                             | 0.046                                                                             | 0.055                                                                             | 0.065                                                                             | 0.07                                                                              | 0.08                                                                               |    |    |  |  |  |  |
| K                                                                                                                                    |                            |       | Vc (m/min)   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |    |    |  |  |  |  |
| 1.1-1.2                                                                                                                              | Grey cast iron             | <1000 | 220          | 0.04                                                                              | 0.055                                                                             | 0.065                                                                             | 0.075                                                                             | 0.085                                                                             | 0.1                                                                                |    |    |  |  |  |  |
| 2.1-2.2                                                                                                                              | Modular cast iron          | <850  | 180          | 0.035                                                                             | 0.05                                                                              | 0.06                                                                              | 0.07                                                                              | 0.08                                                                              | 0.09                                                                               |    |    |  |  |  |  |
| 3.1-3.2                                                                                                                              | Malleable cast iron        | <800  | 160          | 0.035                                                                             | 0.05                                                                              | 0.06                                                                              | 0.07                                                                              | 0.08                                                                              | 0.09                                                                               |    |    |  |  |  |  |
| M                                                                                                                                    |                            |       | Vc (m/min)   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |    |    |  |  |  |  |
| 1.1                                                                                                                                  | Inox, ferritic/martensitic | <850  | 90           | 0.04                                                                              | 0.055                                                                             | 0.065                                                                             | 0.075                                                                             | 0.08                                                                              | 0.1                                                                                |    |    |  |  |  |  |
| 2.1                                                                                                                                  | Inox, austenitic           | <650  | 75           | 0.035                                                                             | 0.05                                                                              | 0.06                                                                              | 0.07                                                                              | 0.075                                                                             | 0.09                                                                               |    |    |  |  |  |  |
| 2.2                                                                                                                                  | Inox, austenitic           | <750  | 70           | 0.032                                                                             | 0.048                                                                             | 0.055                                                                             | 0.065                                                                             | 0.07                                                                              | 0.08                                                                               |    |    |  |  |  |  |
| 3.1                                                                                                                                  | Duplex steel               | <1100 |              |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |    |    |  |  |  |  |
| NOTE   The values marked in turquoise are side applications!                                                                         |                            |       |              |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                    |    |    |  |  |  |  |

## 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

