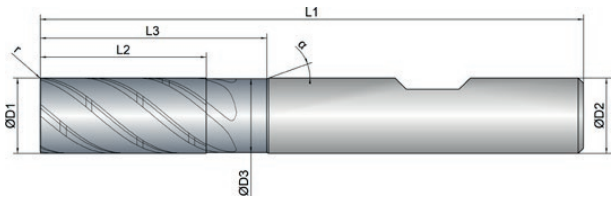
Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X
Strategy	ETC
Application	
Features	HB ≠ 2xD

Expert

- Variable helical pitch with unequal tooth pitch for smooth running and a soft cut
- Adapted chip chambers for trochoidal milling
- Optimized design of the chip breakers for maximum tool life

- For roughing and finishing under ETC conditions
- For process reliable, helical immersion

- Ideal chip evacuation, even with high radial depth of cutting



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M03-0104	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #	r mm	°	α °
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

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	Material	Strength (N/mm²)	Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
			Infeed in mm	ae= 0.13xD ap= Lmax	ae= 0.13xD ap= Lmax	ae= 0.13xD ap= Lmax	ae= 0.13xD ap= Lmax	ae= 0.13xD ap= Lmax	ae= 0.13xD ap= Lmax
			Application						
P			Feed (mm/Z)	fz	fz	fz	fz	fz	fz
			Vc (m/min)						
1.1	Steel, unalloyed	<500	340	0.07	0.09	0.11	0.13	0.16	0.2
1.2-1.5	Steel, unalloyed	<1100	280	0.065	0.085	0.1	0.12	0.15	0.18
2.1-2.2	Steel, low-alloyed	<950	240	0.065	0.085	0.1	0.12	0.15	0.18
2.3-2.4	Steel, low-alloyed	<1300	190	0.06	0.075	0.095	0.11	0.14	0.16
3.1-3.2	Steel, high-alloyed	<1100	210	0.06	0.075	0.095	0.11	0.14	0.16
3.3	Steel, high-alloyed	<1400	180	0.055	0.07	0.09	0.1	0.13	0.15
K			Vc (m/min)						
1.1-1.2	Grey cast iron	<1000	260	0.065	0.085	0.1	0.12	0.15	0.18
2.1-2.2	Modular cast iron	<850	210	0.06	0.075	0.095	0.11	0.14	0.16
3.1-3.2	Malleable cast iron	<800	190	0.055	0.07	0.09	0.1	0.13	0.15
M			Vc (m/min)						
1.1	Inox, ferritic/martensitic	<850	180	0.055	0.07	0.09	0.1	0.13	0.16
2.1	Inox, austenitic	<650	160	0.05	0.065	0.08	0.09	0.12	0.15
2.2	Inox, austenitic	<750	140	0.047	0.06	0.075	0.08	0.11	0.14
3.1	Duplex steel	<1100							

NOTE | The values marked in turquoise are side applications! Values for ETC-milling; please reduce Vc and fz by 20% using trimming.