

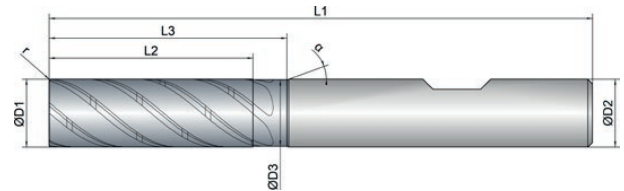
Cooling	   
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC	
Application	  	Expert
Features	HB      	

- 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

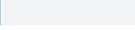
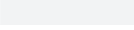
- Ideal chip evacuation, even with high radial depth of cutting

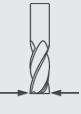
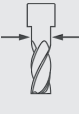
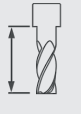
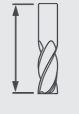
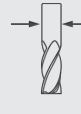


Roughing

				
inappropriate				optimal

Finishing

				
inappropriate				optimal

	D1	D3	L2	L3	L1	D2	z	r		α
EXPK1-M03-0114	 mm $\emptyset$	 mm $\emptyset$	 mm	 mm	 mm	 mm $\emptyset$	 #	 mm	 °	 °
6	6.0	5.8	18.0	25.0	63.0	6.0	5	0.15	40	20
8	8.0	7.8	24.0	30.0	70.0	8.0	5	0.20	40	20
10	10.0	9.8	30.0	35.0	80.0	10.0	5	0.20	40	20
12	12.0	11.8	36.0	45.0	93.0	12.0	5	0.20	40	20
16	16.0	15.8	48.0	55.0	110.0	16.0	5	0.30	40	20
20	20.0	19.8	60.0	70.0	125.0	20.0	5	0.30	40	20



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 Download Catalog Pages (PDF)			Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20							
			Infeed in mm	ae= 0.1xD ap= Lmax	ae= 0.1xD ap= Lmax	ae= 0.1xD ap= Lmax	ae= 0.1xD ap= Lmax	ae= 0.1xD ap= Lmax	ae= 0.1xD ap= Lmax							
			Application													
			Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz					
P			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.																