

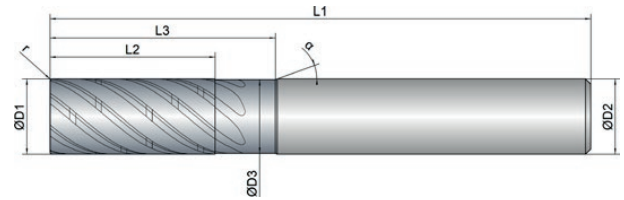
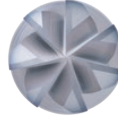
Cooling	   
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC	 			
Application	 				
Features	HA	≠	 	2xD	 

- 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

- 7 cutting edges for best performance with a unique tool life
- Ideal chip evacuation at the highest feed rates

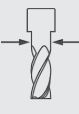
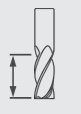
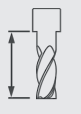
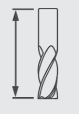
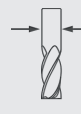


Roughing



Finishing



EXPK1-M03-0203	D1  mm Ø	D3  mm Ø	L2  mm	L3  mm	L1  mm	D2  mm Ø	z  #	r  mm	 °	α  °
6	6.0	5.8	13.0	19.0	57.0	6.0	7	0.15	40	20
8	8.0	7.8	19.0	25.0	63.0	8.0	7	0.20	40	20
10	10.0	9.8	22.0	30.0	72.0	10.0	7	0.20	40	20
12	12.0	11.8	26.0	36.0	83.0	12.0	7	0.20	40	20
16	16.0	15.8	32.0	42.0	92.0	16.0	7	0.30	40	20
20	20.0	19.8	41.0	52.0	104.0	20.0	7	0.30	40	20



Download Catalog
Pages (PDF)



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	fz						
P			Vc (m/min)												
1.1	Steel, unalloyed	<500	340	0.063	0.08	0.1	0.12	0.145	0.18						
1.2-1.5	Steel, unalloyed	<1100	280	0.058	0.076	0.09	0.11	0.135	0.16						
2.1-2.2	Steel, low-alloyed	<950	240	0.058	0.076	0.09	0.11	0.135	0.16						
2.3-2.4	Steel, low-alloyed	<1300	190	0.054	0.068	0.085	0.1	0.125	0.145						
3.1-3.2	Steel, high-alloyed	<1100	210	0.054	0.068	0.085	0.1	0.125	0.145						
3.3	Steel, high-alloyed	<1400	180	0.05	0.063	0.08	0.09	0.115	0.135						
K			Vc (m/min)												
1.1-1.2	Grey cast iron	<1000	260	0.058	0.076	0.09	0.11	0.135	0.16						
2.1-2.2	Modular cast iron	<850	210	0.054	0.068	0.085	0.1	0.125	0.145						
3.1-3.2	Malleable cast iron	<800	190	0.05	0.063	0.08	0.09	0.115	0.135						
M			Vc (m/min)												
1.1	Inox, ferritic/martensitic	<850	180	0.05	0.063	0.08	0.09	0.12	0.145						
2.1	Inox, austenitic	<650	160	0.045	0.058	0.072	0.08	0.11	0.135						
2.2	Inox, austenitic	<750	140	0.042	0.054	0.068	0.072	0.1	0.125						
3.1	Duplex steel	<1100													
NOTE The values marked in turquoise are side applications! We recommend the use of HB shank and side lock arbor. (EXP1-M03-0204) Values for ETC-milling; please reduce Vc and fz by 20% using trimming.															