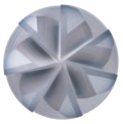
Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC
Application	
Features	HA, ≠, 3xD

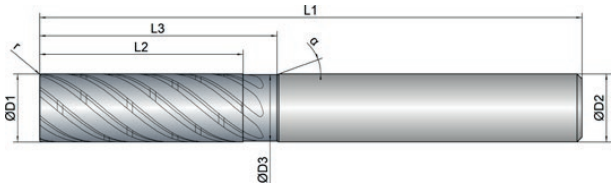
Expert

- 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

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



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M03-0213	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #	r mm	°	α °
6	6.0	5.8	18.0	25.0	63.0	6.0	7	0.15	40	20
8	8.0	7.8	24.0	30.0	70.0	8.0	7	0.20	40	20
10	10.0	9.8	30.0	35.0	80.0	10.0	7	0.20	40	20
12	12.0	11.8	36.0	45.0	93.0	12.0	7	0.20	40	20
16	16.0	15.8	48.0	55.0	110.0	16.0	7	0.30	40	20
20	20.0	19.8	60.0	70.0	125.0	20.0	7	0.30	40	20

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	Material	Strength (N/mm²)	Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
			Infeed in mm	ae= 0.07xD ap= Lmax	ae= 0.07xD ap= Lmax	ae= 0.07xD ap= Lmax	ae= 0.07xD ap= Lmax	ae= 0.07xD ap= Lmax	ae= 0.07xD ap= Lmax
			Application						
			Feed (mm/Z)	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. (EXPK1-M03-0214) Values for ETC-milling; please reduce Vc and fz by 20 % using trimming.

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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