

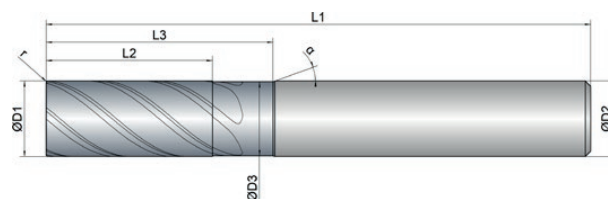
Cooling	   
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC	HPC		
Application				
Features	HA	≠		



- 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

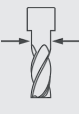
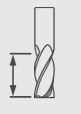
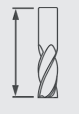
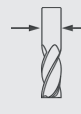


Roughing



Finishing



EXPK1-M01-0223	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	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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 Download Catalog Pages (PDF)			Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20							
			Infeed in mm	ae=0.3xD	ae=0.3xD	ae=0.3xD	ae=0.3xD	ae=0.3xD	ae=0.3xD							
			Application	ap=2xD 	ap=2xD 	ap=2xD 	ap=2xD 	ap=2xD 	ap=2xD 							
			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!																