

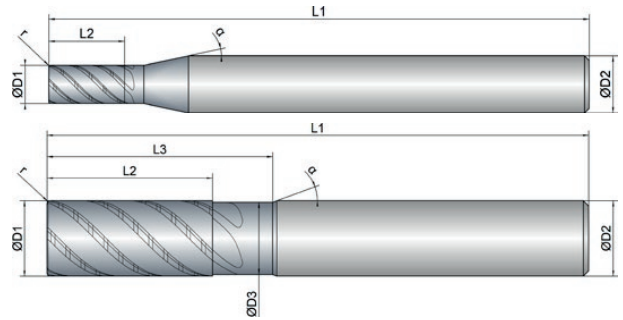
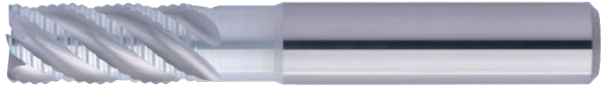
Cooling	   
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC	HPC	 Expert			
Application	   	 				
Features	HA	≠		2xD	 	

- Optimized roughing teeth for soft cut and small chips
- Ascending reinforced tool core for maximum stability
- Variable helical pitch and unequal tooth pitch for smooth running

- For roughing, up to 2xD full slot
- For process reliable, helical immersion

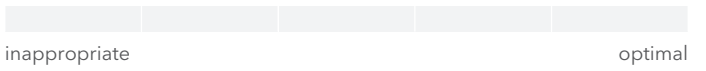
- Extreme material removal at the highest performance
- Also ideally designed for trochoidal milling

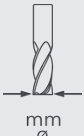
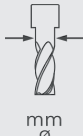


Roughing



Finishing



EXPK1-M02-0123	D1  mm ø	D3  mm ø	L2  mm	L3  mm	L1  mm	D2  mm ø	z  #	r  mm	 °	α  °
4	4.0	0.0	8.0	0.0	57.0	6.0	5	0.10	45	12
6	6.0	5.6	13.0	19.0	57.0	6.0	5	0.20	45	20
8	8.0	7.6	19.0	25.0	63.0	8.0	5	0.20	45	20
10	10.0	9.6	22.0	30.0	72.0	10.0	5	0.32	45	20
12	12.0	11.4	26.0	36.0	83.0	12.0	5	0.32	45	20
16	16.0	15.4	31.0	42.0	92.0	16.0	5	0.32	45	20
20	20.0	19.4	41.0	52.0	104.0	20.0	5	0.50	45	20



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			Dimension	Ø4		Ø6		Ø8		Ø10		Ø12		Ø16	
			Infeed in mm	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD	ae= 1xD	ae= 0.3xD
			Application	ap= 2xD	ap= 2xD	ap= 2xD	ap= 2xD	ap= 2xD	ap= 2xD	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	fz	fz	fz	fz	fz	fz	fz
P			Vc (m/min)												
1.1	Steel, unalloyed	<500	215	0.018	0.025	0.03	0.04	0.04	0.055	0.06	0.08	0.065	0.09	0.07	0.095
1.2-1.5	Steel, unalloyed	<1100	180	0.015	0.023	0.028	0.037	0.037	0.052	0.055	0.075	0.06	0.085	0.065	0.09
2.1-2.2	Steel, low-alloyed	<950	170	0.015	0.023	0.028	0.037	0.037	0.052	0.055	0.075	0.06	0.085	0.065	0.09
2.3-2.4	Steel, low-alloyed	<1300	145	0.012	0.02	0.025	0.034	0.034	0.048	0.05	0.07	0.055	0.08	0.06	0.085
3.1-3.2	Steel, high-alloyed	<1100	160	0.012	0.02	0.025	0.034	0.034	0.048	0.05	0.07	0.055	0.08	0.06	0.085
3.3	Steel, high-alloyed	<1400	135	0.01	0.018	0.022	0.03	0.03	0.045	0.048	0.065	0.05	0.075	0.055	0.08
K			Vc (m/min)												
1.1-1.2	Grey cast iron	<1000	200	0.015	0.023	0.028	0.037	0.037	0.052	0.055	0.075	0.06	0.085	0.065	0.09
2.1-2.2	Modular cast iron	<850	160	0.012	0.02	0.025	0.034	0.034	0.048	0.05	0.07	0.055	0.08	0.06	0.085
3.1-3.2	Malleable cast iron	<800	145	0.012	0.02	0.025	0.034	0.034	0.048	0.05	0.07	0.055	0.08	0.06	0.085
M			Vc (m/min)												
1.1	Inox, ferritic/martensitic	<850	75		0.012		0.025		0.035		0.05		0.06		0.07
2.1	Inox, austenitic	<650	60		0.01		0.022		0.031		0.045		0.055		0.065
2.2	Inox, austenitic	<750	50		0.008		0.02		0.027		0.04		0.05		0.06
3.1	Duplex steel	<1100													
			Dimension	Ø20											
			Infeed in mm	ae= 1xD	ae= 0.3xD										
			Application	ap= 2xD	ap= 2xD										
Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz											
P			Vc (m/min)												
1.1	Steel, unalloyed	<500	215	0.08	0.12										
1.2-1.5	Steel, unalloyed	<1100	180	0.075	0.11										
2.1-2.2	Steel, low-alloyed	<950	170	0.075	0.11										
2.3-2.4	Steel, low-alloyed	<1300	145	0.07	0.1										
3.1-3.2	Steel, high-alloyed	<1100	160	0.07	0.1										
3.3	Steel, high-alloyed	<1400	135	0.065	0.09										
K			Vc (m/min)												
1.1-1.2	Grey cast iron	<1000	200	0.075	0.11										
2.1-2.2	Modular cast iron	<850	160	0.07	0.1										
3.1-3.2	Malleable cast iron	<800	145	0.07	0.1										
M			Vc (m/min)												
1.1	Inox, ferritic/martensitic	<850	75		0.08										
2.1	Inox, austenitic	<650	60		0.07										
2.2	Inox, austenitic	<750	50		0.065										
3.1	Duplex steel	<1100													
NOTE The values marked in turquoise are side applications!															