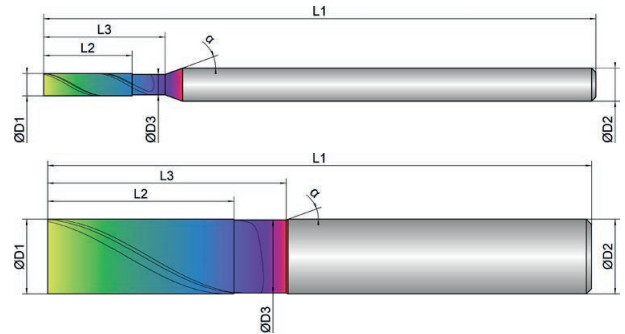


Cooling	
Tolerance	e8
Coating	AlphaSlide Rainbow

Strategy	<b>ETC</b>	<b>HPC</b>
Application		
Features	<b>HA</b>	



- Extra sharp cutting edges for a smooth and soft cut in all plastics
- Highly polished chip space for optimized chip evacuation
- Special helical pitch for smooth running



**Roughing**



**Finishing**



EXN1-M01-0013	D1  mm ∅	D3  mm ∅	L2  mm	L3  mm	L1  mm	D2  mm ∅	z  #	 °	α  °
1	1.0	0.9	5.0	8.0	50.0	3.0	2	20	20
2	2.0	1.85	8.0	11.0	50.0	3.0	2	20	20
3	3.0	2.8	11.0	14.0	50.0	3.0	2	20	20
4	4.0	3.8	13.0	16.0	54.0	4.0	2	20	20
5	5.0	4.8	15.0	18.0	54.0	5.0	2	20	20
6	6.0	5.8	16.0	21.0	65.0	6.0	2	20	20
8	8.0	7.8	22.0	27.0	70.0	8.0	2	20	20
10	10.0	9.8	25.0	32.0	73.0	10.0	2	20	20
12	12.0	11.8	28.0	38.0	84.0	12.0	3	20	20
14	14.0	13.8	30.0	42.0	84.0	14.0	3	20	20
16	16.0	15.8	36.0	44.0	93.0	16.0	3	20	20
20	20.0	19.8	41.0	54.0	104.0	20.0	3	20	20



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Dimension	Ø1		Ø2		Ø3		Ø4		Ø5		Ø6	
Infeed in mm	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD
Application	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD

Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
N		Vc (m/min)													
1.1	Aluminium, alloyed	<500													
1.2	Aluminium, alloyed	<600													
2.1-2.3	Aluminium, casted	<600													
3.1-3.3	Cooper, alloyed	<650													
4.1	Magnesium, alloyed	<250													
5.1	Thermoplastic	<100	480	0.004	0.007	0.006	0.01	0.008	0.012	0.012	0.02	0.015	0.025	0.025	0.04
5.2	Duroplastic	<150	420	0.003	0.006	0.005	0.009	0.006	0.01	0.01	0.016	0.01	0.02	0.02	0.035

Dimension	Ø8		Ø10		Ø12		Ø14		Ø16		Ø20	
Infeed in mm	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD	ae= 1xD	ae= 0.4xD
Application	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD	ap= 1xD	ap= 2xD

Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
N		Vc (m/min)													
1.1	Aluminium, alloyed	<500													
1.2	Aluminium, alloyed	<600													
2.1-2.3	Aluminium, casted	<600													
3.1-3.3	Cooper, alloyed	<650													
4.1	Magnesium, alloyed	<250													
5.1	Thermoplastic	<100	480	0.03	0.05	0.04	0.055	0.048	0.075	0.05	0.085	0.055	0.09	0.06	0.11
5.2	Duroplastic	<150	420	0.025	0.045	0.035	0.05	0.044	0.065	0.04	0.075	0.045	0.08	0.05	0.1