

Cooling

Tolerance e8

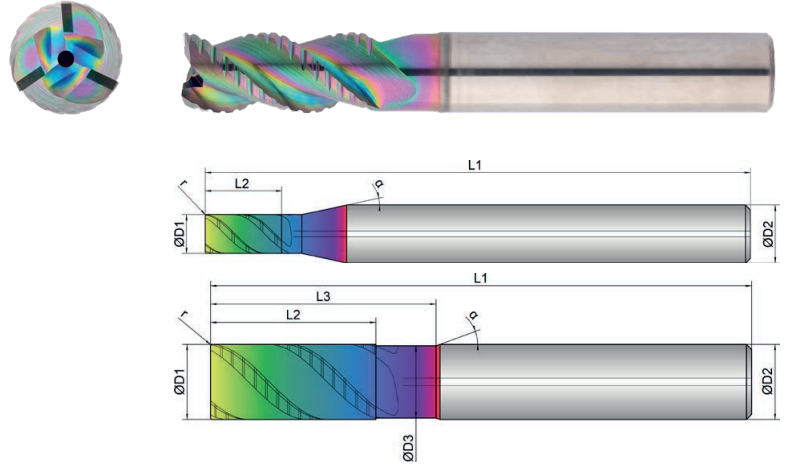
Coating AlphaSlide Rainbow

Strategy ETC HPC

Application

Features HA ≠

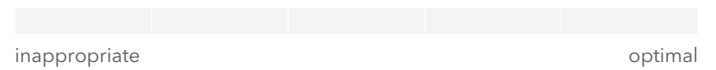
- Roughing teeth for the smallest chips in volume machining
 - Special helical pitch for smooth running and soft cut
 - Extra large chip chambers for an extreme chip volume
-
- For roughing, up to 2xD full slot
 - For process reliable, helical diving and immersion
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- With central inner cooling
 - Also ideally designed for trochoidal milling



Roughing



Finishing



	D1	D3	L2	L3	L1	D2	z	r	α
EXN1-M02-0123	mm ∅	mm ∅	mm	mm	mm	mm ∅	#	mm	°
4	4.0	0.0	8.0	0.0	57.0	6.0	3	0.10	45
5	5.0	0.0	9.0	0.0	57.0	6.0	3	0.20	45
6	6.0	5.6	13.0	19.0	57.0	6.0	3	0.20	45
8	8.0	7.6	19.0	25.0	63.0	8.0	3	0.20	45
10	10.0	9.6	22.0	30.0	72.0	10.0	3	0.32	45
12	12.0	11.4	26.0	36.0	83.0	12.0	3	0.32	45
16	16.0	15.4	31.0	42.0	92.0	16.0	3	0.32	45
20	20.0	19.4	41.0	52.0	104.0	20.0	3	0.50	45



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Material	Strength (N/mm ²)	Feed (mm/Z)	Ø4		Ø5		Ø6		Ø8		Ø10		Ø12		
			ae=1xD ap=2xD	ae=0.6xD ap=2xD	ae=1xD ap=2xD	ae=0.6xD ap=2xD	ae=1xD ap=2xD	ae=0.6xD ap=2xD	ae=1xD ap=2xD	ae=0.6xD ap=2xD	ae=1xD ap=2xD	ae=0.6xD ap=2xD	ae=1xD ap=2xD	ae=0.6xD ap=2xD	
N		Vc (m/min)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
1.1	Aluminium, alloyed	<500	500	0.035	0.05	0.05	0.07	0.07	0.09	0.09	0.11	0.11	0.13	0.13	0.15
1.2	Aluminium, alloyed	<600	480	0.035	0.05	0.05	0.07	0.07	0.09	0.09	0.11	0.11	0.13	0.13	0.15
2.1-2.3	Aluminium, casted	<600	450	0.03	0.045	0.045	0.065	0.065	0.085	0.085	0.1	0.1	0.12	0.12	0.14
3.1-3.3	Cooper, alloyed	<650	200	0.025	0.04	0.04	0.06	0.06	0.08	0.08	0.095	0.09	0.11	0.11	0.13
4.1	Magnesium, alloyed	<250	500	0.035	0.05	0.05	0.07	0.07	0.09	0.09	0.11	0.11	0.13	0.13	0.15
5.1	Thermoplastic	<100	350	0.03	0.045	0.035	0.05	0.05	0.07	0.06	0.07	0.07	0.09	0.07	0.11
5.2	Duroplastic	<150	300	0.025	0.04	0.03	0.045	0.045	0.06	0.05	0.06	0.06	0.08	0.06	0.1

Material	Strength (N/mm ²)	Feed (mm/Z)	Ø16		Ø20					
			ae=1xD ap=2xD	ae=0.6xD ap=2xD	ae=1xD ap=2xD	ae=0.6xD ap=2xD				
N		Vc (m/min)	fz	fz	fz	fz				
1.1	Aluminium, alloyed	<500	500	0.14	0.16	0.18	0.22			
1.2	Aluminium, alloyed	<600	480	0.14	0.16	0.18	0.22			
2.1-2.3	Aluminium, casted	<600	450	0.13	0.15	0.16	0.2			
3.1-3.3	Cooper, alloyed	<650	200	0.12	0.14	0.14	0.18			
4.1	Magnesium, alloyed	<250	500	0.14	0.16	0.18	0.22			
5.1	Thermoplastic	<100	350	0.11	0.14	0.14	0.18			
5.2	Duroplastic	<150	300	0.1	0.13	0.13	0.17			

NOTE | The values marked in turquoise are side applications!