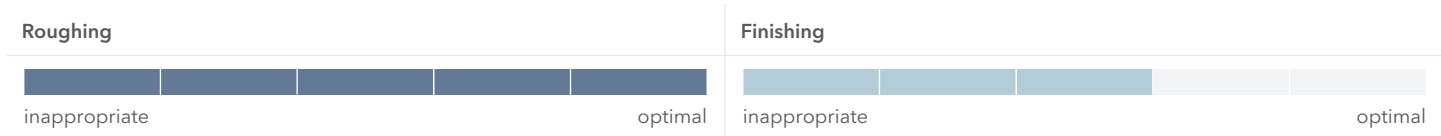
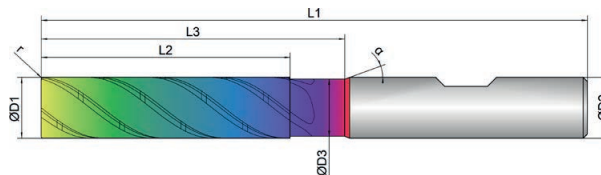


Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	ETC	
Application		
Features	HB ≠ 4xD	



- Chip breaker for short, defined chip length
 - Unequal tooth pitch combined with variable helical pitch for smooth running
 - Reinforced face with 2 cutting edges to the center
-
- For roughing and finishing under ETC conditions
 - For process reliable, helical immersion
-
- Ideal chip evacuation, even with high radial depth of cutting



EXN1-M03-0044	D1 mm ∅	D3 mm ∅	L2 mm	L3 mm	L1 mm	D2 mm ∅	z #	r mm	 °	α °
10	10.0	9.4	41.0	50.0	90.0	10.0	4	0.20	38	20
12	12.0	11.4	49.0	60.0	110.0	12.0	4	0.20	38	20
16	16.0	15.4	65.0	80.0	130.0	16.0	4	0.30	38	20
20	20.0	19.4	82.0	100.0	150.0	20.0	4	0.30	38	20



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Dimension	Ø10	Ø12	Ø16	Ø20						
Infeed in mm	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max						
Application										

Material	Strength (N/mm ²)	Feed (mm/Z)								
		fz	fz	fz	fz					
N		Vc (m/min)								
1.1	Aluminium, alloyed	<500	520	0.085	0.1	0.14	0.17			
1.2	Aluminium, alloyed	<600	500	0.085	0.1	0.14	0.17			
2.1-2.3	Aluminium, casted	<600	480	0.08	0.09	0.13	0.16			
3.1-3.3	Cooper, alloyed	<650	220	0.075	0.08	0.12	0.15			
4.1	Magnesium, alloyed	<250	520	0.085	0.1	0.14	0.17			
5.1	Thermoplastic	<100								
5.2	Duroplastic	<150								