

Cooling


Tolerance e8

Coating AlphaFerro Platin X

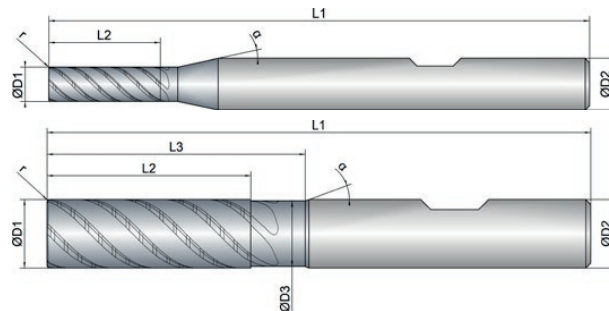
Strategy **ETC** **HPC**

Application

Features **HB**  $\neq$  **3xD**

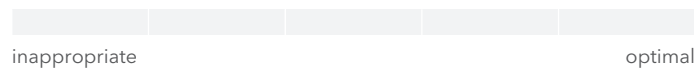


- Optimiertes Kordelprofil für weichen Schnitt und kleine Späne
  - Leicht konisch verstärkter Werkzeugkern für maximale Stabilität
  - Variable Drallsteigung und Ungleichteilung für ruhigen Lauf
- 
- For roughing, up to 2xD full slot
  - Zum Prozesssicheren helikalen Eintauchen
- 
- Extremer Materialabtrag bei höchster Performance
  - Auch zum trochoidalen Fräsen bestens geeignet



**Roughing**

**Finishing**



	D1	D3	L2	L3	L1	D2	z	r	$\alpha$
EXPK1-M02-0154	mm $\varnothing$	mm $\varnothing$	mm	mm	mm	mm $\varnothing$	#	mm	°
4	4.0	0.0	13.0	0.0	63.0	6.0	5	0.10	45
6	6.0	5.6	18.0	24.0	63.0	6.0	5	0.20	45
8	8.0	7.6	24.0	30.0	70.0	8.0	5	0.20	45
10	10.0	9.6	30.0	38.0	80.0	10.0	5	0.32	45
12	12.0	11.4	36.0	46.0	93.0	12.0	5	0.32	45
16	16.0	15.4	48.0	58.0	110.0	16.0	5	0.32	45
20	20.0	19.4	60.0	74.0	125.0	20.0	5	0.50	45



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Material	Strength (N/mm <sup>2</sup> )	Dimension	Infeed in mm	Application	Ø4		Ø6		Ø8		Ø10		Ø12		Ø16	
					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
		Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
<b>P</b>		Vc (m/min)														
1.1	Steel, unalloyed	<500	205	0.015	0.022	0.025	0.035	0.035	0.05	0.055	0.075	0.06	0.085	0.065	0.09	
1.2-1.5	Steel, unalloyed	<1100	170	0.012	0.02	0.022	0.032	0.032	0.048	0.05	0.07	0.055	0.08	0.06	0.085	
2.1-2.2	Steel, low-alloyed	<950	160	0.012	0.02	0.022	0.032	0.032	0.048	0.05	0.07	0.055	0.08	0.06	0.085	
2.3-2.4	Steel, low-alloyed	<1300	135	0.01	0.018	0.02	0.03	0.03	0.043	0.045	0.065	0.05	0.075	0.055	0.08	
3.1-3.2	Steel, high-alloyed	<1100	150	0.01	0.018	0.02	0.03	0.03	0.043	0.045	0.065	0.05	0.075	0.055	0.08	
3.3	Steel, high-alloyed	<1400	125	0.008	0.015	0.018	0.025	0.025	0.04	0.042	0.06	0.045	0.07	0.05	0.075	

<b>K</b>	Vc (m/min)															
1.1-1.2	Grey cast iron	<1000	190	0.012	0.02	0.022	0.032	0.032	0.048	0.05	0.07	0.055	0.08	0.06	0.085	
2.1-2.2	Modular cast iron	<850	150	0.01	0.018	0.02	0.03	0.03	0.043	0.045	0.065	0.05	0.075	0.055	0.08	
3.1-3.2	Malleable cast iron	<800	135	0.01	0.018	0.02	0.03	0.03	0.043	0.045	0.065	0.05	0.075	0.055	0.08	

<b>M</b>	Vc (m/min)															
1.1	Inox, ferritic/martensitic	<850	70		0.01		0.022		0.032		0.045		0.055		0.065	
2.1	Inox, austenitic	<650	55		0.008		0.02		0.028		0.04		0.05		0.06	
2.2	Inox, austenitic	<750	45		0.006		0.018		0.025		0.035		0.045		0.055	
3.1	Duplex steel	<1100														

Material	Strength (N/mm <sup>2</sup> )	Dimension	Infeed in mm	Application	Ø20											
					ae=1xD	ae=0.3xD	ap=2xD	ap=2xD	Feed (mm/Z)	fz	fz					
<b>P</b>		Vc (m/min)														
1.1	Steel, unalloyed	<500	205	0.075	0.11											
1.2-1.5	Steel, unalloyed	<1100	170	0.07	0.1											
2.1-2.2	Steel, low-alloyed	<950	160	0.07	0.1											
2.3-2.4	Steel, low-alloyed	<1300	135	0.065	0.09											
3.1-3.2	Steel, high-alloyed	<1100	150	0.065	0.09											
3.3	Steel, high-alloyed	<1400	125	0.06	0.08											
<b>K</b>		Vc (m/min)														
1.1-1.2	Grey cast iron	<1000	190	0.07	0.1											
2.1-2.2	Modular cast iron	<850	150	0.065	0.09											
3.1-3.2	Malleable cast iron	<800	135	0.065	0.09											
<b>M</b>		Vc (m/min)														
1.1	Inox, ferritic/martensitic	<850	70		0.075											
2.1	Inox, austenitic	<650	55		0.065											
2.2	Inox, austenitic	<750	45		0.06											
3.1	Duplex steel	<1100														

**NOTE** | The values marked in turquoise are side applications!