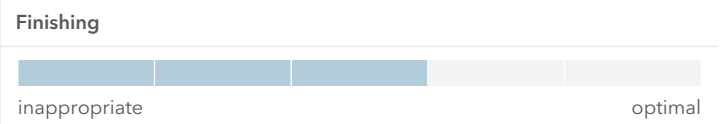
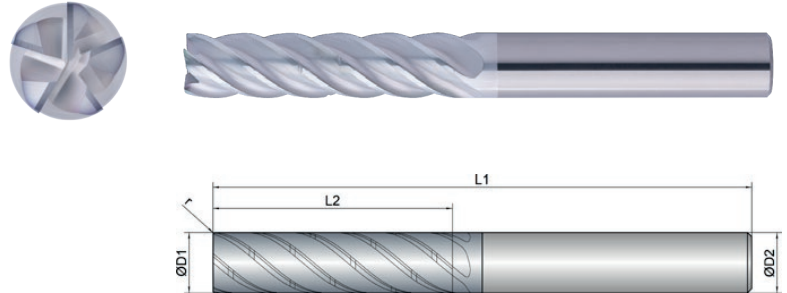


Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC	
Application		Expert
Features	HA ≠ 4xD	

- Variable helical pitch with unequal tooth pitch for smooth running and a soft cut
 - Adapted chip chambers for trochoidal milling
 - Optimized design of the chip breakers for maximum tool life
-
- For roughing and finishing under ETC conditions
 - For process reliable, helical immersion
-
- Ideal chip evacuation, even with high radial depth of cutting



EXPK1-M03-0123	D1 mm ∅	L2 mm	L1 mm	D2 mm ∅	z #	r mm	 °
6	6.0	24.0	68.0	6.0	5	0.15	40
8	8.0	32.0	75.0	8.0	5	0.20	40
10	10.0	40.0	90.0	10.0	5	0.20	40
12	12.0	48.0	100.0	12.0	5	0.20	40
16	16.0	64.0	125.0	16.0	5	0.30	40
20	20.0	80.0	150.0	20.0	5	0.30	40



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Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20						
Infeed in mm	ae= 0.07xD	ae= 0.07xD	ae= 0.07xD	ae= 0.07xD	ae= 0.07xD	ae= 0.07xD						
Application	ap= Lmax	ap= Lmax	ap= Lmax	ap= Lmax	ap= Lmax	ap= Lmax						

Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz
P									
Vc (m/min)									
1.1	Steel, unalloyed	<500	340	0.065	0.085	0.1	0.12	0.15	0.18
1.2-1.5	Steel, unalloyed	<1100	280	0.06	0.08	0.09	0.11	0.14	0.16
2.1-2.2	Steel, low-alloyed	<950	240	0.06	0.08	0.09	0.11	0.14	0.16
2.3-2.4	Steel, low-alloyed	<1300	190	0.055	0.075	0.085	0.1	0.13	0.14
3.1-3.2	Steel, high-alloyed	<1100	210	0.055	0.075	0.085	0.1	0.13	0.14
3.3	Steel, high-alloyed	<1400	180	0.05	0.07	0.08	0.09	0.12	0.13
K									
Vc (m/min)									
1.1-1.2	Grey cast iron	<1000	260	0.06	0.08	0.09	0.11	0.14	0.16
2.1-2.2	Modular cast iron	<850	210	0.055	0.075	0.085	0.1	0.13	0.14
3.1-3.2	Malleable cast iron	<800	190	0.05	0.07	0.08	0.09	0.12	0.13
M									
Vc (m/min)									
1.1	Inox, ferritic/martensitic	<850	180	0.05	0.065	0.08	0.09	0.12	0.15
2.1	Inox, austenitic	<650	160	0.045	0.06	0.07	0.08	0.11	0.14
2.2	Inox, austenitic	<750	140	0.042	0.055	0.065	0.07	0.1	0.13
3.1	Duplex steel	<1100							

NOTE | The values marked in turquoise are side applications! We recommend the use of HB shank and side lock arbor. (EXPK1-M03-0124) Values for ETC-milling; please reduce Vc and fz by 20% using trimming.