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			Dimension	Ø3		Ø4		Ø5		Ø6		Ø8		Ø10	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD
			Application												
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
N			Vc (m/min)												
1.1	Aluminium, alloyed	<500	500	0.04	0.05	0.05	0.06	0.055	0.07	0.06	0.08	0.08	0.1	0.09	0.12
1.2	Aluminium, alloyed	<600	480	0.04	0.05	0.05	0.06	0.055	0.07	0.06	0.08	0.08	0.1	0.09	0.12
2.1-2.3	Aluminium, casted	<600	450	0.035	0.045	0.045	0.055	0.05	0.065	0.055	0.075	0.075	0.09	0.08	0.11
3.1-3.3	Cooper, alloyed	<650	200	0.03	0.04	0.04	0.05	0.045	0.06	0.05	0.07	0.07	0.085	0.075	0.1
4.1	Magnesium, alloyed	<250	500	0.04	0.05	0.05	0.06	0.055	0.07	0.06	0.08	0.08	0.1	0.09	0.12
5.1	Thermoplastic	<100	400	0.03	0.04	0.04	0.045	0.04	0.05	0.045	0.065	0.055	0.065	0.065	0.085
5.2	Duroplastic	<150	350	0.025	0.035	0.03	0.035	0.035	0.04	0.035	0.055	0.045	0.055	0.055	0.075

			Dimension	Ø12		Ø16		Ø20	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 2xD
			Application						
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz
N			Vc (m/min)						
1.1	Aluminium, alloyed	<500	500	0.1	0.14	0.14	0.18	0.18	0.22
1.2	Aluminium, alloyed	<600	480	0.1	0.14	0.14	0.18	0.18	0.22
2.1-2.3	Aluminium, casted	<600	450	0.09	0.13	0.13	0.17	0.17	0.2
3.1-3.3	Cooper, alloyed	<650	200	0.085	0.12	0.12	0.16	0.16	0.18
4.1	Magnesium, alloyed	<250	500	0.1	0.14	0.14	0.18	0.18	0.22
5.1	Thermoplastic	<100	400	0.075	0.11	0.11	0.13	0.13	0.17
5.2	Duroplastic	<150	350	0.065	0.1	0.1	0.12	0.12	0.16

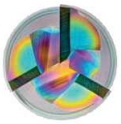
Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

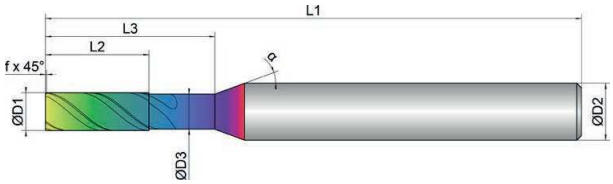
Strategy	ETC HPC
Application	
Features	HA ≠

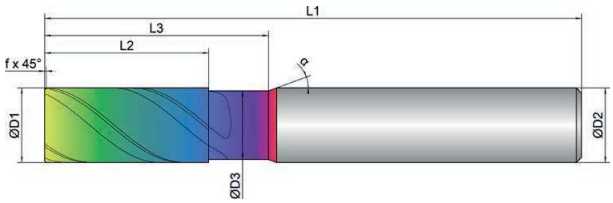
Expert

- Defined clearance angle for ideal stabilization with high cutting depths
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume

- For process reliable, helical diving and immersion
- For roughing and finishing, up to 2xD full slot







Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M01-0103	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #	45° mm	°
3	3.0	2.7	8.0	12.0	57.0	6.0	3	0.10	45
4	4.0	3.7	11.0	18.0	57.0	6.0	3	0.10	45
5	5.0	4.7	13.0	18.0	57.0	6.0	3	0.10	45
6	6.0	5.7	13.0	18.0	57.0	6.0	3	0.20	45
8	8.0	7.4	21.0	25.0	63.0	8.0	3	0.20	45
10	10.0	9.2	22.0	30.0	72.0	10.0	3	0.20	45
12	12.0	11.0	26.0	36.0	83.0	12.0	3	0.20	45
16	16.0	15.0	36.0	42.0	92.0	16.0	3	0.20	45
20	20.0	19.0	41.0	52.0	104.0	20.0	3	0.20	45