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Dimension	Ø5		Ø6		Ø8		Ø10		Ø12		Ø16	
Infeed in mm	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
Application	ap= 1xD	ap= 3xD	ap= 1xD	ap= 3xD	ap= 1xD	ap= 3xD	ap= 1xD	ap= 3xD	ap= 1xD	ap= 3xD	ap= 1xD	ap= 3xD

Material	Strength (N/mm ²)	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	0.045	0.06	0.05	0.07	0.07	0.09	0.08	0.11	0.09	0.13	0.13	0.16
1.2	Aluminium, alloyed	<600	480	0.045	0.06	0.05	0.07	0.07	0.09	0.08	0.11	0.09	0.13	0.13	0.16
2.1-2.3	Aluminium, casted	<600	450	0.04	0.055	0.045	0.065	0.06	0.08	0.07	0.1	0.08	0.12	0.12	0.15
3.1-3.3	Cooper, alloyed	<650	200	0.035	0.05	0.04	0.06	0.05	0.07	0.06	0.09	0.07	0.11	0.11	0.14
4.1	Magnesium, alloyed	<250	500	0.045	0.06	0.05	0.07	0.07	0.09	0.08	0.11	0.09	0.13	0.13	0.16
5.1	Thermoplastic	<100	400	0.03	0.045	0.04	0.06	0.05	0.06	0.06	0.08	0.07	0.1	0.1	0.13
5.2	Duroplastic	<150	350	0.025	0.04	0.035	0.055	0.04	0.05	0.05	0.07	0.06	0.09	0.09	0.12

Dimension	Ø20						
Infeed in mm	ae= 1xD	ae= 0.3xD					
Application	ap= 1xD	ap= 3xD					

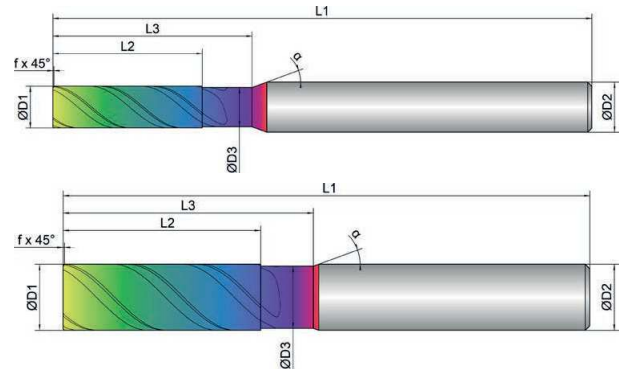
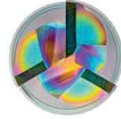
Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	
N		Vc (m/min)			
1.1	Aluminium, alloyed	<500	500	0.16	0.2
1.2	Aluminium, alloyed	<600	480	0.16	0.2
2.1-2.3	Aluminium, casted	<600	450	0.15	0.19
3.1-3.3	Cooper, alloyed	<650	200	0.14	0.18
4.1	Magnesium, alloyed	<250	500	0.16	0.2
5.1	Thermoplastic	<100	400	0.13	0.17
5.2	Duroplastic	<150	350	0.12	0.16

Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	ETC	HPC		
Application				
Features	HA	≠	3xD	



- 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



Roughing



Finishing



EXN1-M01-0123	D1	D3	L2	L3	L1	D2	z	45°	α	α
	mm Ø	mm Ø	mm	mm	mm	mm Ø	#	mm	°	°
5	5.0	4.7	18.0	24.0	65.0	6.0	3	0.10	45	20
6	6.0	5.5	20.0	24.0	65.0	6.0	3	0.20	45	20
8	8.0	7.5	26.0	30.0	70.0	8.0	3	0.20	45	20
10	10.0	9.4	30.0	38.0	80.0	10.0	3	0.20	45	20
12	12.0	11.4	36.0	46.0	93.0	12.0	3	0.20	45	20
16	16.0	15.4	48.0	58.0	110.0	16.0	3	0.20	45	20
20	20.0	19.4	60.0	74.0	125.0	20.0	3	0.20	45	20