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			Dimension	Ø5	Ø6	Ø8	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	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max			
			Application										
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz			
N			Vc (m/min)										
1.1	Aluminium, alloyed	<500	520	0.04	0.05	0.07	0.085	0.1	0.14	0.17			
1.2	Aluminium, alloyed	<600	500	0.04	0.05	0.07	0.085	0.1	0.14	0.17			
2.1-2.3	Aluminium, casted	<600	480	0.035	0.045	0.065	0.08	0.09	0.13	0.16			
3.1-3.3	Cooper, alloyed	<650	220	0.025	0.035	0.06	0.075	0.08	0.12	0.15			
4.1	Magnesium, alloyed	<250	520	0.04	0.05	0.07	0.085	0.1	0.14	0.17			
5.1	Thermoplastic	<100											
5.2	Duroplastic	<150											

NOTE | From Ø10 we recommend the use of HB shank and side lock arbor (EXN1-M03-0044).

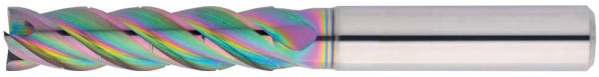
Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow
Strategy	ETC
Application	
Features	HA, ≠, 4xD

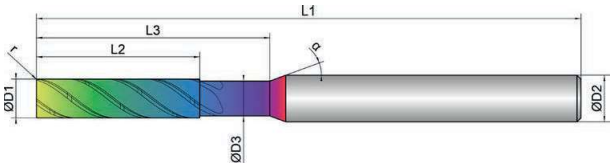
Expert

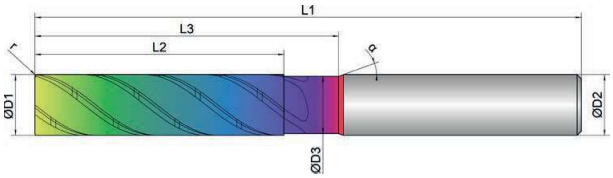
- Chip breaker for short, defined chip length
- Unequal tooth pitch combined with variable helical pitch for smooth running
- Reinforced face with 2 cutting edges to the center

- For roughing and finishing under ETC conditions
- For process reliable, helical immersion

- Ideal chip evacuation, even with high radial depth of cutting







Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M03-0043	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	r mm	°	α °
5	5.0	4.5	21.0	30.0	70.0	6.0	4	0.15	38	20
6	6.0	5.5	25.0	30.0	70.0	6.0	4	0.15	38	20
8	8.0	7.5	33.0	40.0	80.0	8.0	4	0.20	38	20
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