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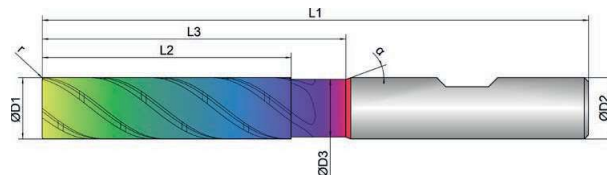
Dimension	Ø10	Ø12	Ø16	Ø20						
Infeed in mm	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max	ae= 0.1xD ap= L2 max						
Application										

Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	Vc (m/min)				
			fz	fz	fz	fz	
<b>N</b>			<b>Vc (m/min)</b>				
1.1	Aluminium, alloyed	<500	520	0.085	0.1	0.14	0.17
1.2	Aluminium, alloyed	<600	500	0.085	0.1	0.14	0.17
2.1-2.3	Aluminium, casted	<600	480	0.08	0.09	0.13	0.16
3.1-3.3	Cooper, alloyed	<650	220	0.075	0.08	0.12	0.15
4.1	Magnesium, alloyed	<250	520	0.085	0.1	0.14	0.17
5.1	Thermoplastic	<100					
5.2	Duroplastic	<150					

Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	<b>ETC</b>	
Application		
Features	<b>HB</b> <b>≠</b> <b>4xD</b>	

- 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
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- For roughing and finishing under ETC conditions
  - For process reliable, helical immersion
- 
- Ideal chip evacuation, even with high radial depth of cutting



**Roughing**



**Finishing**



	D1	D3	L2	L3	L1	D2	z	r		α
EXN1-M03-0044										
	mm ∅	mm ∅	mm	mm	mm	mm ∅	#	mm	°	°
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