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| Dimension | Ø10 | Ø12 | Ø16 | Ø20 | | | | | | |
|--------------|---|---|---|---|--|--|--|--|--|--|
| Infeed in mm | ae= 0.07xD ap= L2 max | ae= 0.07xD ap= L2 max | ae= 0.07xD ap= L2 max | ae= 0.07xD ap= L2 max | | | | | | |
| Application |  |  |  |  | | | | | | |

| Material | Strength (N/mm ²) | Feed (mm/Z) | | | | | | | | |
|----------|-------------------------------|-------------|-----|------|-------|------|------|--|--|--|
| | | fz | fz | fz | fz | | | | | |
| N | | Vc (m/min) | | | | | | | | |
| 1.1 | Aluminium, alloyed | <500 | 500 | 0.08 | 0.095 | 0.13 | 0.16 | | | |
| 1.2 | Aluminium, alloyed | <600 | 480 | 0.08 | 0.095 | 0.13 | 0.16 | | | |
| 2.1-2.3 | Aluminium, casted | <600 | 460 | 0.07 | 0.085 | 0.12 | 0.15 | | | |
| 3.1-3.3 | Cooper, alloyed | <650 | 200 | 0.06 | 0.075 | 0.11 | 0.14 | | | |
| 4.1 | Magnesium, alloyed | <250 | 500 | 0.08 | 0.095 | 0.13 | 0.16 | | | |
| 5.1 | Thermoplastic | <100 | | | | | | | | |
| 5.2 | Duroplastic | <150 | | | | | | | | |

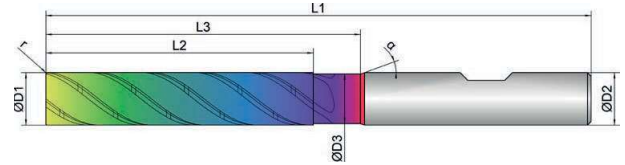
| | |
|-----------|--------------------|
| Cooling | |
| Tolerance | h6 |
| Coating | AlphaSlide Rainbow |

| | | |
|-------------|-------------------------------|--|
| Strategy | ETC | |
| Application | | |
| Features | HB ≠ 5xD | |

- 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



Finishing



| | D1 | D3 | L2 | L3 | L1 | D2 | z | r | | α |
|---------------|---------|---------|-------|-------|-------|---------|---|------|----|----|
| EXN1-M03-0054 | | | | | | | | | | |
| | mm ∅ | mm ∅ | mm | mm | mm | mm ∅ | # | mm | ° | ° |
| 10 | 10.0 | 9.5 | 51.0 | 60.0 | 104.0 | 10.0 | 4 | 0.20 | 38 | 20 |
| 12 | 12.0 | 11.0 | 61.0 | 72.0 | 120.0 | 12.0 | 4 | 0.20 | 38 | 20 |
| 16 | 16.0 | 15.0 | 81.0 | 96.0 | 150.0 | 16.0 | 4 | 0.30 | 38 | 20 |
| 20 | 20.0 | 19.0 | 102.0 | 120.0 | 175.0 | 20.0 | 4 | 0.30 | 38 | 20 |