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Dimension	Ø0.5	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12
Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD
Application										

Material	Strength (N/mm ²)	Feed (mm/Z)	Vc (m/min)	Strength (N/mm ²)																
				fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz						
N																				
1.1	Aluminium, alloyed	<500	550	0.008	0.013	0.018	0.022	0.025	0.045	0.055	0.06	0.07	0.08							
1.2	Aluminium, alloyed	<600	525	0.008	0.013	0.018	0.022	0.025	0.045	0.055	0.06	0.07	0.08							
2.1-2.3	Aluminium, casted	<600	460	0.006	0.01	0.016	0.019	0.022	0.04	0.05	0.055	0.065	0.07							
3.1-3.3	Cooper, alloyed	<650	240	0.005	0.007	0.014	0.016	0.018	0.035	0.045	0.05	0.06	0.06							
4.1	Magnesium, alloyed	<250	550	0.008	0.013	0.018	0.022	0.025	0.045	0.055	0.06	0.07	0.08							
5.1	Thermoplastic	<100	420	0.006	0.01	0.016	0.019	0.022	0.04	0.05	0.055	0.065	0.07							
5.2	Duroplastic	<150	340	0.005	0.007	0.014	0.016	0.018	0.035	0.045	0.05	0.06	0.06							

Cooling	
Tolerance	f8
Coating	AlphaSlide Rainbow

Strategy	HSC
Application	
Features	HA

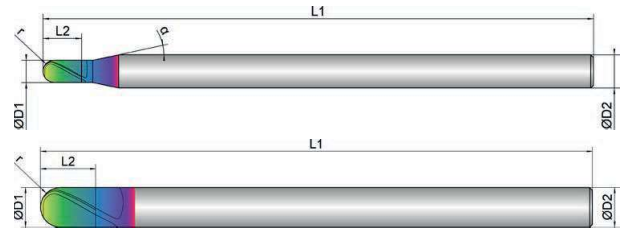


- Optimized face geometry for excellent surfaces
- Defined microbevel for support and stabilization
- Special chip chambers designed for optimal chip evacuation



- Long version for deeper cavities
- For use in HSC milling
- For roughing and finishing

- Radius tolerance $r \leq 2 \text{ mm}$: $\pm 0.003 \text{ mm}$
- Radius tolerance $r > 2 \text{ mm}$: $\pm 0.005 \text{ mm}$



Roughing



Finishing



EXN1-M08-0013	D1 mm ø	L2 mm	L1 mm	D2 mm ø	z #	r mm	 °	α °
0,5	0.5	1.0	75.0	6.0	2	0.25	45	12
1	1.0	2.0	75.0	6.0	2	0.50	45	12
2	2.0	4.0	75.0	6.0	2	1.00	45	12
3	3.0	6.0	75.0	6.0	2	1.50	45	12
4	4.0	7.0	75.0	6.0	2	2.00	45	12
5	5.0	8.0	100.0	6.0	2	2.50	45	12
6	6.0	10.0	100.0	6.0	2	3.00	45	0
8	8.0	12.0	100.0	8.0	2	4.00	45	0
10	10.0	14.0	100.0	10.0	2	5.00	45	0
12	12.0	16.0	100.0	12.0	2	6.00	45	0