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	Material	Strength (N/mm²)	Dimension	Ø0.2x0.5			Ø0.2x3			Ø0.3x1			Ø0.3x6		
			Infeed in mm	ae= 1xD ap= 0.2xD	ae= 0.25xD ap= L2 max	ae= 0.1xD ae= 0.1xD	ae= 1xD ap= 0.06xD	ae= 0.05xD ap= L2 max	ae= 0.05xD ae= 0.05xD	ae= 1xD ap= 0.2xD	ae= 0.25xD ap= L2 max	ae= 0.1xD ae= 0.1xD	ae= 1xD ap= 0.02xD	ae= 0.03xD ap= L2 max	ae= 0.01xD ae= 0.01xD
			Application												
			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	0.008	0.012	0.014	0.005	0.007	0.009	0.008	0.012	0.014	0.005	0.007	0.009
1.2	Aluminium, alloyed	<600	480	0.008	0.012	0.014	0.005	0.007	0.009	0.008	0.012	0.014	0.005	0.007	0.009
2.1-2.3	Aluminium, casted	<600	450	0.007	0.011	0.013	0.004	0.006	0.008	0.007	0.011	0.013	0.004	0.006	0.008
3.1-3.3	Cooper, alloyed	<650	220	0.006	0.01	0.012	0.003	0.005	0.007	0.006	0.01	0.012	0.003	0.005	0.007
4.1	Magnesium, alloyed	<250	500	0.008	0.012	0.014	0.005	0.007	0.009	0.008	0.012	0.014	0.005	0.007	0.009
5.1	Thermoplastic	<100	400	0.007	0.011	0.013	0.004	0.006	0.008	0.007	0.011	0.013	0.004	0.006	0.008
5.2	Duroplastic	<150	350	0.006	0.01	0.012	0.003	0.005	0.007	0.006	0.01	0.012	0.003	0.005	0.007

	Material	Strength (N/mm²)	Dimension	Ø0.4x1			Ø0.4x8			Ø0.5x1			Ø0.5x10		
			Infeed in mm	ae= 1xD ap= 0.2xD	ae= 0.25xD ap= L2 max	ae= 0.1xD ae= 0.1xD	ae= 1xD ap= 0.02xD	ae= 0.03xD ap= L2 max	ae= 0.01xD ae= 0.01xD	ae= 1xD ap= 0.2xD	ae= 0.25xD ap= L2 max	ae= 0.1xD ae= 0.1xD	ae= 1xD ap= 0.02xD	ae= 0.03xD ap= L2 max	ae= 0.01xD ae= 0.01xD
			Application												
			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	0.012	0.016	0.018	0.005	0.007	0.009	0.016	0.02	0.022	0.009	0.013	0.015
1.2	Aluminium, alloyed	<600	480	0.012	0.016	0.018	0.005	0.007	0.009	0.016	0.02	0.022	0.009	0.013	0.015
2.1-2.3	Aluminium, casted	<600	450	0.011	0.015	0.017	0.004	0.006	0.008	0.015	0.018	0.021	0.008	0.012	0.014
3.1-3.3	Cooper, alloyed	<650	220	0.01	0.014	0.016	0.003	0.005	0.007	0.014	0.016	0.02	0.007	0.011	0.013
4.1	Magnesium, alloyed	<250	500	0.012	0.016	0.018	0.005	0.007	0.009	0.016	0.02	0.022	0.009	0.013	0.015
5.1	Thermoplastic	<100	400	0.011	0.015	0.017	0.004	0.006	0.008	0.015	0.018	0.021	0.008	0.012	0.014
5.2	Duroplastic	<150	350	0.01	0.014	0.016	0.003	0.005	0.007	0.014	0.016	0.02	0.007	0.011	0.013

	Material	Strength (N/mm²)	Dimension	Ø0.6x3			Ø0.6x10		
			Infeed in mm	ae= 1xD ap= 0.2xD	ae= 0.25xD ap= L2 max	ae= 0.1xD ae= 0.1xD	ae= 1xD ap= 0.03xD	ae= 0.04xD ap= L2 max	ae= 0.015xD ae= 0.015xD
			Application						
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz
N			Vc (m/min)						
1.1	Aluminium, alloyed	<500	500	0.016	0.02	0.022	0.012	0.015	0.017
1.2	Aluminium, alloyed	<600	480	0.016	0.02	0.022	0.012	0.015	0.017
2.1-2.3	Aluminium, casted	<600	450	0.015	0.018	0.021	0.011	0.014	0.016
3.1-3.3	Cooper, alloyed	<650	220	0.014	0.016	0.02	0.01	0.013	0.015
4.1	Magnesium, alloyed	<250	500	0.016	0.02	0.022	0.012	0.015	0.017
5.1	Thermoplastic	<100	400	0.015	0.018	0.021	0.011	0.014	0.016
5.2	Duroplastic	<150	350	0.014	0.016	0.02	0.01	0.013	0.015

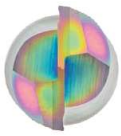
NOTE | Values in the table are the shortest and the longest overhang length (L3) of each dimension; please calculate fz, ap and ae depending on the given values.
ae/ap(max) = 0.5x corner radius!

Cooling	
Tolerance	d04
Coating	AlphaSlide Rainbow

Strategy	HSC
Application	
Features	HA

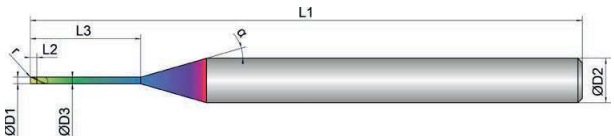
Expert

- Optimized face geometry for excellent surfaces and highest dimensional accuracy
- Defined microbevel for support and stabilization
- Polished chip space for ideal chip evacuation



- Multipass milling of 3D contours

- Tolerance D1: -0.001/-0.006 mm
- Tolerance D3: 0/-0.02 mm
- Radius tolerance r: 0/-0.003 mm (measured from 0-90°)



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M16-0023	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	r mm	°	α °
0,2X0,5	0.2	0.18	0.2	0.5	50.0	4.0	2	0.05	30	16
0,2X1	0.2	0.18	0.2	1.0	50.0	4.0	2	0.05	30	16
0,2X2	0.2	0.18	0.2	2.0	50.0	4.0	2	0.05	30	16
0,2X3	0.2	0.18	0.2	3.0	50.0	4.0	2	0.05	30	16
0,3X1	0.3	0.28	0.3	1.0	50.0	4.0	2	0.05	30	16
0,3X2	0.3	0.28	0.3	2.0	50.0	4.0	2	0.05	30	16
0,3X3	0.3	0.28	0.3	3.0	50.0	4.0	2	0.05	30	16
0,3X4	0.3	0.28	0.3	4.0	50.0	4.0	2	0.05	30	16
0,3X6	0.3	0.28	0.3	6.0	50.0	4.0	2	0.05	30	16
0,4X1	0.4	0.38	0.4	1.0	50.0	4.0	2	0.05	30	16
0,4X2	0.4	0.38	0.4	2.0	50.0	4.0	2	0.05	30	16

EXN1-M16-0023	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #	r mm	°	α °
0,4X3	0.4	0.38	0.4	3.0	50.0	4.0	2	0.05	30	16
0,4X4	0.4	0.38	0.4	4.0	50.0	4.0	2	0.05	30	16
0,4X6	0.4	0.38	0.4	6.0	50.0	4.0	2	0.05	30	16
0,4X8	0.4	0.38	0.4	8.0	50.0	4.0	2	0.05	30	16
0,5X1	0.5	0.48	0.5	1.0	50.0	4.0	2	0.05	30	16
0,5X2	0.5	0.48	0.5	2.0	50.0	4.0	2	0.05	30	16
0,5X3	0.5	0.48	0.5	3.0	50.0	4.0	2	0.05	30	16
0,5X4	0.5	0.48	0.5	4.0	50.0	4.0	2	0.05	30	16
0,5X6	0.5	0.48	0.5	6.0	50.0	4.0	2	0.05	30	16
0,5X8	0.5	0.48	0.5	8.0	50.0	4.0	2	0.05	30	16
0,5X10	0.5	0.48	0.5	10.0	50.0	4.0	2	0.05	30	16
0,6X3	0.6	0.58	0.6	3.0	50.0	4.0	2	0.05	30	16
0,6X4	0.6	0.58	0.6	4.0	50.0	4.0	2	0.05	30	16
0,6X6	0.6	0.58	0.6	6.0	50.0	4.0	2	0.05	30	16
0,6X8	0.6	0.58	0.6	8.0	50.0	4.0	2	0.05	30	16
0,6X10	0.6	0.58	0.6	10.0	50.0	4.0	2	0.05	30	16

STILL CAN'T FIND A SUITABLE MILLING CUTTER?

No problem – simply customize an existing tool. Using our configurator for special milling cutters, you can customize existing tools to your needs in an instant or create your own tools based on predefined types.

WE WILL RESPOND TO ALL REQUESTS SUBMITTED VIA THE CONFIGURATOR WITHIN ONE WORKING DAY AT THE LATEST