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	Material	Strength (N/mm²)	Dimension	Ø3		Ø4		Ø5		Ø6		Ø8		Ø10	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD
			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	280	0.03	0.04	0.04	0.05	0.05	0.065	0.055	0.065	0.06	0.075	0.075	0.09
1.2	Aluminium, alloyed	<600	260	0.03	0.04	0.04	0.05	0.05	0.065	0.055	0.065	0.06	0.075	0.075	0.09
2.1-2.3	Aluminium, casted	<600	240	0.025	0.035	0.035	0.045	0.04	0.055	0.045	0.055	0.05	0.065	0.065	0.08
3.1-3.3	Cooper, alloyed	<650	120	0.02	0.03	0.03	0.035	0.03	0.045	0.035	0.045	0.04	0.055	0.055	0.07
4.1	Magnesium, alloyed	<250	280	0.03	0.04	0.04	0.05	0.05	0.065	0.055	0.065	0.06	0.075	0.075	0.09
5.1	Thermoplastic	<100	200	0.025	0.035	0.035	0.045	0.04	0.055	0.045	0.055	0.05	0.065	0.065	0.08
5.2	Duroplastic	<150	170	0.02	0.03	0.03	0.035	0.03	0.045	0.035	0.045	0.04	0.055	0.055	0.07

	Material	Strength (N/mm²)	Dimension	Ø12		Ø16		Ø20	
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD
			Application						
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz
N			Vc (m/min)						
1.1	Aluminium, alloyed	<500	280	0.08	0.1	0.1	0.12	0.12	0.14
1.2	Aluminium, alloyed	<600	260	0.08	0.1	0.1	0.12	0.12	0.14
2.1-2.3	Aluminium, casted	<600	240	0.07	0.09	0.09	0.11	0.11	0.13
3.1-3.3	Cooper, alloyed	<650	120	0.06	0.08	0.08	0.1	0.1	0.12
4.1	Magnesium, alloyed	<250	280	0.08	0.1	0.1	0.12	0.12	0.14
5.1	Thermoplastic	<100	200	0.07	0.09	0.09	0.11	0.11	0.13
5.2	Duroplastic	<150	170	0.06	0.08	0.08	0.1	0.1	0.12

Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

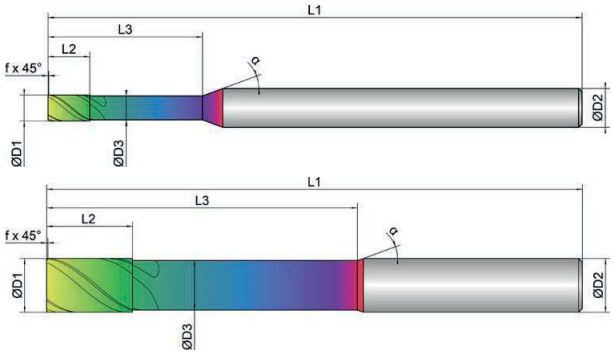
Strategy	ETC, HPC
Application	
Features	HA

Expert

- Defined clearance angle for ideal stabilization with high cutting depths
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume

- For process reliable, helical diving and immersion
- For roughing and finishing

- Long version for deeper cavities



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M01-0113	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	45° mm	°
3	3.0	2.7	5.0	18.0	83.0	6.0	3	0.10	45
4	4.0	3.7	6.5	24.0	83.0	6.0	3	0.10	45
5	5.0	4.7	8.0	30.0	83.0	6.0	3	0.10	45
6	6.0	5.7	10.0	42.0	83.0	6.0	3	0.20	45
8	8.0	7.4	13.0	62.0	100.0	8.0	3	0.20	45
10	10.0	9.2	16.0	58.0	100.0	10.0	3	0.20	45
12	12.0	11.0	19.0	73.0	119.0	12.0	3	0.20	45
16	16.0	15.0	25.0	100.0	150.0	16.0	3	0.20	45
20	20.0	19.0	32.0	98.0	150.0	20.0	3	0.20	45