











Download Catalog Pages (PDF)

Dimension	Ø5	Ø6	Ø8	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	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			
1.1	Aluminium, alloyed	<500	500	0.035	0.05	0.065	0.08	0.095	0.13	0.16
1.2	Aluminium, alloyed	<600	480	0.035	0.05	0.065	0.08	0.095	0.13	0.16
2.1-2.3	Aluminium, casted	<600	460	0.03	0.045	0.06	0.07	0.085	0.12	0.15
3.1-3.3	Cooper, alloyed	<650	200	0.02	0.04	0.05	0.06	0.075	0.11	0.14
4.1	Magnesium, alloyed	<250	500	0.035	0.045	0.065	0.08	0.095	0.13	0.16
5.1	Thermoplastic	<100								
5.2	Duroplastic	<150								


NOTE | From Ø10 we recommend the use of HB shank and side lock arbor (EXN1-M03-0054).


Cooling 


Tolerance h6

Coating AlphaSlide Rainbow

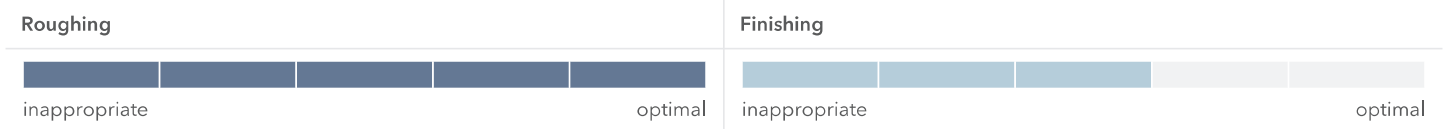
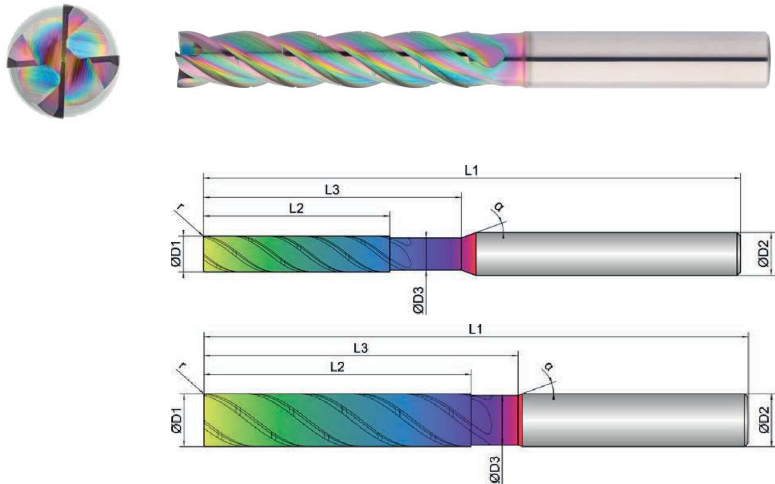
Strategy **ETC**


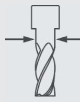
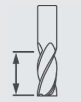
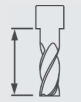
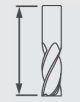
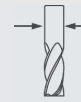




Application 

Features **HA** \neq 



- 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



EXN1-M03-0053	D1  mm ∅	D3  mm ∅	L2  mm	L3  mm	L1  mm	D2  mm ∅	z  #	r  mm	 °	α  °
5	5.0	4.5	26.0	36.0	75.0	6.0	4	0.15	38	20
6	6.0	5.5	31.0	36.0	75.0	6.0	4	0.15	38	20
8	8.0	7.5	41.0	48.0	90.0	8.0	4	0.20	38	20
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