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	Material	Strength (N/mm²)	Dimension	Ø1		Ø1.5		Ø2		Ø3		Ø4		Ø5	
			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	500	0.015	0.02	0.015	0.02	0.02	0.025	0.025	0.035	0.03	0.04	0.035	0.045
1.2	Aluminium, alloyed	<600	480	0.015	0.02	0.015	0.02	0.02	0.025	0.025	0.035	0.03	0.04	0.035	0.045
2.1-2.3	Aluminium, casted	<600	450	0.01	0.015	0.01	0.015	0.015	0.02	0.02	0.03	0.025	0.035	0.03	0.04
3.1-3.3	Cooper, alloyed	<650	200	0.008	0.012	0.008	0.012	0.012	0.015	0.015	0.025	0.02	0.03	0.025	0.035
4.1	Magnesium, alloyed	<250	500	0.015	0.02	0.015	0.02	0.02	0.025	0.025	0.035	0.03	0.04	0.035	0.045
5.1	Thermoplastic	<100	400	0.01	0.015	0.01	0.015	0.015	0.02	0.02	0.03	0.025	0.035	0.03	0.04
5.2	Duroplastic	<150	350	0.008	0.012	0.008	0.012	0.012	0.015	0.015	0.025	0.02	0.03	0.025	0.035

	Material	Strength (N/mm²)	Dimension	Ø6		Ø8		Ø10		Ø12	
			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
			Application								
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz
N			Vc (m/min)								
1.1	Aluminium, alloyed	<500	500	0.045	0.055	0.05	0.06	0.06	0.07	0.075	0.1
1.2	Aluminium, alloyed	<600	480	0.045	0.055	0.05	0.06	0.06	0.07	0.075	0.1
2.1-2.3	Aluminium, casted	<600	450	0.04	0.05	0.045	0.055	0.055	0.065	0.07	0.09
3.1-3.3	Cooper, alloyed	<650	200	0.035	0.045	0.04	0.05	0.05	0.06	0.06	0.08
4.1	Magnesium, alloyed	<250	500	0.045	0.055	0.05	0.06	0.06	0.07	0.075	0.1
5.1	Thermoplastic	<100	400	0.04	0.05	0.045	0.055	0.055	0.065	0.07	0.09
5.2	Duroplastic	<150	350	0.035	0.045	0.04	0.05	0.05	0.06	0.06	0.08

Cooling	
Tolerance	h10
Coating	AlphaSlide Rainbow

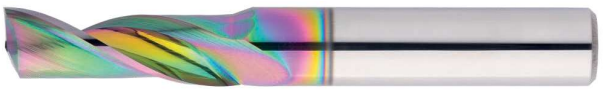
Strategy	HSC HPC
Application	
Features	HA

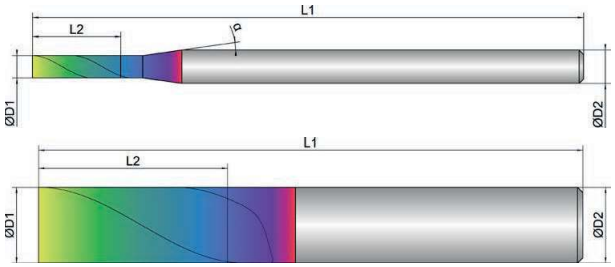
Expert

- Defined clearance angle for ideal stabilization with high cutting depths
- Special helical pitch for smooth running and soft cut
- Balanced for maximum smoothness

- For roughing and finishing, up to 1.5xD full slot
- For process reliable, helical diving and immersion

- For use in high speed milling machines





Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M05-0023	D1 mm ø	L2 mm	L1 mm	D2 mm ø	z #	°	α °
1	1.0	4.0	50.0	3.0	1	30	8
1,5	1.5	6.0	50.0	3.0	1	30	8
2	2.0	8.0	50.0	3.0	1	30	8
3	3.0	12.0	50.0	3.0	1	30	0
4	4.0	15.0	54.0	4.0	1	30	0
5	5.0	17.0	54.0	5.0	1	30	0
6	6.0	20.0	65.0	6.0	1	30	0
8	8.0	22.0	63.0	8.0	1	30	0
10	10.0	25.0	72.0	10.0	1	30	0
12	12.0	30.0	83.0	12.0	1	30	0