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			Dimension	Ø5			Ø6			Ø8			Ø10		
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD
			Application												
	Material	Strength (N/mm²)	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	0.055	0.07	0.08	0.06	0.08	0.09	0.08	0.1	0.11	0.09	0.12	0.13
1.2	Aluminium, alloyed	<600	480	0.055	0.07	0.08	0.06	0.08	0.09	0.08	0.1	0.11	0.09	0.12	0.13
2.1-2.3	Aluminium, casted	<600	450	0.05	0.065	0.075	0.055	0.075	0.085	0.075	0.09	0.1	0.08	0.11	0.12
3.1-3.3	Cooper, alloyed	<650	200	0.045	0.06	0.07	0.05	0.07	0.08	0.07	0.085	0.095	0.075	0.1	0.11
4.1	Magnesium, alloyed	<250	500	0.055	0.07	0.08	0.06	0.08	0.09	0.08	0.1	0.11	0.09	0.12	0.13
5.1	Thermoplastic	<100	400	0.04	0.05	0.06	0.045	0.065	0.075	0.055	0.065	0.075	0.065	0.085	0.095
5.2	Duroplastic	<150	350	0.035	0.04	0.05	0.035	0.055	0.065	0.045	0.055	0.065	0.055	0.075	0.085

			Dimension	Ø12			Ø16			Ø20		
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ap= 0.04xD
			Application									
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz
N			Vc (m/min)									
1.1	Aluminium, alloyed	<500	500	0.1	0.14	0.16	0.14	0.18	0.2	0.18	0.22	0.24
1.2	Aluminium, alloyed	<600	480	0.1	0.14	0.16	0.14	0.18	0.2	0.18	0.22	0.24
2.1-2.3	Aluminium, casted	<600	450	0.09	0.13	0.15	0.13	0.17	0.19	0.17	0.2	0.22
3.1-3.3	Cooper, alloyed	<650	200	0.085	0.12	0.14	0.12	0.16	0.18	0.16	0.18	0.2
4.1	Magnesium, alloyed	<250	500	0.1	0.14	0.16	0.14	0.18	0.2	0.18	0.22	0.24
5.1	Thermoplastic	<100	400	0.075	0.11	0.12	0.11	0.13	0.14	0.13	0.17	0.18
5.2	Duroplastic	<150	350	0.065	0.1	0.11	0.1	0.12	0.13	0.12	0.16	0.17

NOTE | By using multipass milling the maximum infeed (ae, ap) is 0.5x corner radius!

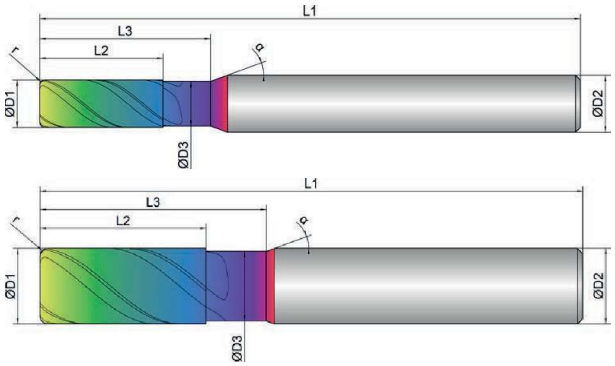
Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	HSC HPC
Application	
Features	HA ≠ 2xD

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, up to 1.5xD full slot
- Multipass milling of 3D contours



- Radius tolerance r ≤ 1.5 mm: ± 0.003 mm
- Radius tolerance r > 1.5 mm: ± 0.005 mm

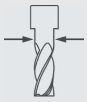
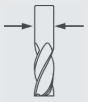
Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXN1-M06-0003	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	r mm	°	α °
5/0,5	5.0	4.7	13.0	18.0	57.0	6.0	3	0.50	45	20
5/1	5.0	4.7	13.0	18.0	57.0	6.0	3	1.00	45	20
6/0,5	6.0	5.7	13.0	18.0	57.0	6.0	3	0.50	45	20
6/1	6.0	5.7	13.0	18.0	57.0	6.0	3	1.00	45	20
8/0,5	8.0	7.4	21.0	25.0	63.0	8.0	3	0.50	45	20
8/1	8.0	7.4	21.0	25.0	63.0	8.0	3	1.00	45	20
10/0,5	10.0	9.2	22.0	30.0	72.0	10.0	3	0.50	45	20
10/1	10.0	9.2	22.0	30.0	72.0	10.0	3	1.00	45	20
10/2	10.0	9.2	22.0	30.0	72.0	10.0	3	2.00	45	20
12/0,5	12.0	11.0	26.0	36.0	83.0	12.0	3	0.50	45	20

EXN1-M06-0003	D1  mm ø	D3  mm ø	L2  mm	L3  mm	L1  mm	D2  mm ø	z  #	r  mm	 °	α  °
12/1	12.0	11.0	26.0	36.0	83.0	12.0	3	1.00	45	20
12/2	12.0	11.0	26.0	36.0	83.0	12.0	3	2.00	45	20
16/1	16.0	15.0	36.0	42.0	92.0	16.0	3	1.00	45	20
16/2	16.0	15.0	36.0	42.0	92.0	16.0	3	2.00	45	20
16/3	16.0	15.0	36.0	42.0	92.0	16.0	3	3.00	45	20
20/1	20.0	19.0	41.0	52.0	104.0	20.0	3	1.00	45	20
20/2	20.0	19.0	41.0	52.0	104.0	20.0	3	2.00	45	20
20/3	20.0	19.0	41.0	52.0	104.0	20.0	3	3.00	45	20
20/4	20.0	19.0	41.0	52.0	104.0	20.0	3	4.00	45	20