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Material	Strength (N/mm ²)	Feed (mm/Z)	Ø5		Ø6		Ø8		Ø10		Ø12		Ø16			
			ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD	ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD
N			Vc (m/min)													
1.1	Aluminium, alloyed	<500	280	0.065 0.075	0.065 0.075	0.075 0.085	0.09	0.1	0.1	0.12	0.12	0.12	0.12	0.14		
1.2	Aluminium, alloyed	<600	260	0.065 0.075	0.065 0.075	0.075 0.085	0.09	0.1	0.1	0.12	0.12	0.12	0.12	0.14		
2.1-2.3	Aluminium, casted	<600	240	0.055 0.065	0.055 0.065	0.065 0.075	0.08	0.09	0.09	0.11	0.11	0.11	0.13			
3.1-3.3	Cooper, alloyed	<650	120	0.045 0.055	0.045 0.055	0.055 0.065	0.07	0.08	0.08	0.1	0.1	0.1	0.12			
4.1	Magnesium, alloyed	<250	280	0.065 0.075	0.065 0.075	0.075 0.085	0.09	0.1	0.1	0.12	0.12	0.12	0.14			
5.1	Thermoplastic	<100	200	0.055 0.065	0.055 0.065	0.065 0.075	0.08	0.09	0.09	0.11	0.11	0.11	0.13			
5.2	Duroplastic	<150	170	0.045 0.055	0.045 0.055	0.055 0.065	0.07	0.08	0.08	0.1	0.1	0.1	0.12			

Material	Strength (N/mm ²)	Feed (mm/Z)	Ø20	
			ae=0.3xD ap=1xD	ae=0.04xD ap=0.04xD
N			Vc (m/min)	
1.1	Aluminium, alloyed	<500	280	0.14 0.16
1.2	Aluminium, alloyed	<600	260	0.14 0.16
2.1-2.3	Aluminium, casted	<600	240	0.13 0.15
3.1-3.3	Cooper, alloyed	<650	120	0.12 0.14
4.1	Magnesium, alloyed	<250	280	0.14 0.16
5.1	Thermoplastic	<100	200	0.13 0.15
5.2	Duroplastic	<150	170	0.12 0.14

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	≠	

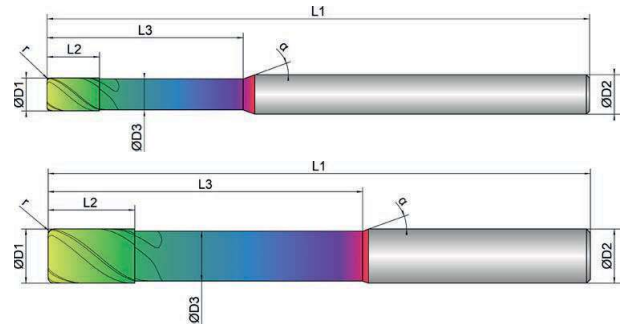


- Defined clearance angle for ideal stabilization with high cutting depths
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume



- Long version for deeper cavities
- For roughing and finishing
- Multipass milling of 3D contours

- Radius tolerance $r \leq 1.5 \text{ mm}$: $\pm 0.003 \text{ mm}$
- Radius tolerance $r > 1.5 \text{ mm}$: $\pm 0.005 \text{ mm}$



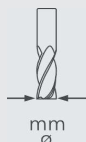
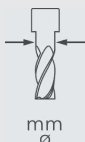

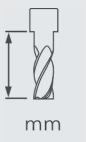
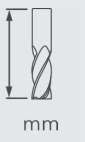





Roughing



Finishing



EXN1-M06-0013	D1 mm ∅	D3 mm ∅	L2 mm	L3 mm	L1 mm	D2 mm ∅	z #	r mm	 °	α °
5/0,5	5.0	4.7	8.0	30.0	83.0	6.0	3	0.50	45	20
5/1	5.0	4.7	8.0	30.0	83.0	6.0	3	1.00	45	20
6/0,5	6.0	5.7	10.0	42.0	83.0	6.0	3	0.50	45	20
6/1	6.0	5.7	10.0	42.0	83.0	6.0	3	1.00	45	20
8/0,5	8.0	7.4	13.0	62.0	100.0	8.0	3	0.50	45	20
8/1	8.0	7.4	13.0	62.0	100.0	8.0	3	1.00	45	20
10/0,5	10.0	9.2	16.0	58.0	100.0	10.0	3	0.50	45	20
10/1	10.0	9.2	16.0	58.0	100.0	10.0	3	1.00	45	20
10/2	10.0	9.2	16.0	58.0	100.0	10.0	3	2.00	45	20
12/0,5	12.0	11.0	19.0	73.0	119.0	12.0	3	0.50	45	20

EXN1-M06-0013	 D1 mm ∅	 D3 mm ∅	 L2 mm	 L3 mm	 L1 mm	 D2 mm ∅	 z #	 r mm	 °	 α °
12/1	12.0	11.0	19.0	73.0	119.0	12.0	3	1.00	45	20
12/2	12.0	11.0	19.0	73.0	119.0	12.0	3	2.00	45	20
16/1	16.0	15.0	25.0	100.0	150.0	16.0	3	1.00	45	20
16/2	16.0	15.0	25.0	100.0	150.0	16.0	3	2.00	45	20
16/3	16.0	15.0	25.0	100.0	150.0	16.0	3	3.00	45	20
20/1	20.0	19.0	32.0	98.0	150.0	20.0	3	1.00	45	20
20/2	20.0	19.0	32.0	98.0	150.0	20.0	3	2.00	45	20
20/3	20.0	19.0	32.0	98.0	150.0	20.0	3	3.00	45	20
20/4	20.0	19.0	32.0	98.0	150.0	20.0	3	4.00	45	20