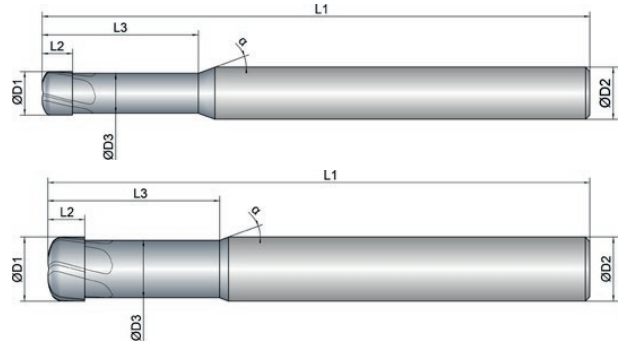


Cooling	
Tolerance	h9
Coating	AlphaFerro Platin X

Strategy	HSC
Application	
Features	HA \neq



- Vertical absorption of the cutting force through special division of the cutting edges
 - Geometry with tangential transitions for HSC milling
 - Soft cut through targeted positive rake angles
-
- For roughing and finishing under HSC conditions
-
- Check programming radius and ap max. according to the variant table



Roughing












Finishing



EXPK1-M07-0023	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	 mm	 mm max	 °	α °
2	2.0	1.7	1.5	13.0	54.0	6.0	2	0.3	0.15	15	20
3	3.0	2.7	1.5	15.0	54.0	6.0	2	0.3	0.20	15	20
4	4.0	3.6	2.5	16.0	57.0	6.0	2	0.5	0.25	15	20
5	5.0	4.6	3.5	18.0	63.0	6.0	4	0.5	0.35	15	20
6	6.0	5.2	3.5	20.0	63.0	6.0	4	1.0	0.40	15	20
8	8.0	7.0	4.8	24.0	70.0	8.0	5	1.5	0.50	15	20
10	10.0	9.0	5.8	26.0	85.0	10.0	5	2.0	0.75	15	20
12	12.0	11.0	6.8	30.0	93.0	12.0	5	2.0	0.80	15	20
16	16.0	14.5	8.8	35.0	100.0	16.0	5	2.5	1.00	15	20



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Dimension	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø16
Infeed in mm	ae= 1xD ap _{max} = 0.15mm	ae= 1xD ap _{max} = 0.2mm	ae= 1xD ap _{max} = 0.25mm	ae= 1xD ap _{max} = 0.35mm	ae= 1xD ap _{max} = 0.4mm	ae= 1xD ap _{max} = 0.5mm	ae= 1xD ap _{max} = 0.75mm	ae= 1xD ap _{max} = 0.8mm	ae= 1xD ap _{max} = 1.0mm
Application									

Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	
P			Vc (m/min)									
1.1	Steel, unalloyed	<500	170	0.035	0.05	0.07	0.08	0.09	0.12	0.15	0.22	0.25
1.2-1.5	Steel, unalloyed	<1100	155	0.03	0.045	0.065	0.075	0.085	0.11	0.14	0.2	0.24
2.1-2.2	Steel, low-alloyed	<950	145	0.03	0.045	0.065	0.075	0.085	0.11	0.14	0.2	0.24
2.3-2.4	Steel, low-alloyed	<1300	125	0.025	0.04	0.06	0.07	0.08	0.1	0.13	0.19	0.23
3.1-3.2	Steel, high-alloyed	<1100	140	0.025	0.04	0.06	0.07	0.08	0.1	0.13	0.19	0.23
3.3	Steel, high-alloyed	<1400	115	0.022	0.035	0.058	0.068	0.078	0.095	0.12	0.18	0.22
K			Vc (m/min)									
1.1-1.2	Grey cast iron	<1000	190	0.03	0.045	0.065	0.075	0.085	0.11	0.14	0.2	0.24
2.1-2.2	Modular cast iron	<850	155	0.025	0.04	0.06	0.07	0.08	0.1	0.13	0.19	0.23
3.1-3.2	Malleable cast iron	<800	135	0.025	0.04	0.06	0.07	0.08	0.1	0.13	0.19	0.23
M			Vc (m/min)									
1.1	Inox, ferritic/martensitic	<850	110	0.03	0.045	0.065	0.075	0.085	0.11	0.14	0.2	0.24
2.1	Inox, austenitic	<650	100	0.025	0.04	0.06	0.07	0.08	0.1	0.13	0.18	0.22
2.2	Inox, austenitic	<750	90	0.022	0.038	0.055	0.065	0.075	0.09	0.12	0.17	0.2
3.1	Duplex steel	<1100										

NOTE | The values marked in turquoise are side applications!