Cooling	
Tolerance	h9
Coating	AlphaFerro Platin X

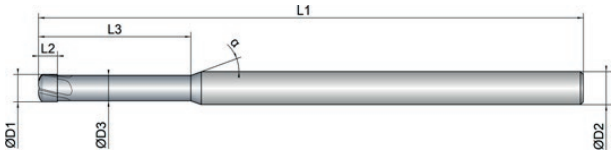
Strategy	HSC
Application	
Features	HA

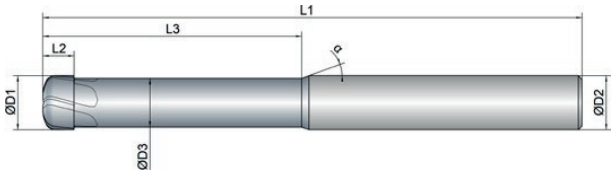
Expert

- 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

- Long version for deeper cavities
- For roughing and finishing under HSC conditions

- Check programming radius and ap max. according to the variant table





Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M07-0043	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #	mm	mm max	°	α °
2	2.0	1.7	1.5	18.0	75.0	6.0	2	0.3	0.15	15	20
3	3.0	2.7	1.5	20.0	75.0	6.0	2	0.3	0.20	15	20
4	4.0	3.6	2.5	24.0	83.0	6.0	2	0.5	0.25	15	20
5	5.0	4.6	3.5	28.0	100.0	6.0	4	0.5	0.35	15	20
6	6.0	5.2	3.5	28.0	100.0	6.0	4	1.0	0.40	15	20
8	8.0	7.0	4.8	40.0	100.0	8.0	5	1.5	0.50	15	20
10	10.0	9.0	5.8	48.0	100.0	10.0	5	2.0	0.75	15	20
12	12.0	11.0	6.8	56.0	119.0	12.0	5	2.0	0.80	15	20
16	16.0	14.5	8.8	65.0	150.0	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} = 0.1.0mm
			Application									
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz
P			Vc (m/min)									
1.1	Steel, unalloyed	<500	150	0.03	0.045	0.06	0.07	0.08	0.11	0.14	0.2	0.23
1.2-1.5	Steel, unalloyed	<1100	140	0.025	0.04	0.055	0.065	0.075	0.1	0.13	0.18	0.22
2.1-2.2	Steel, low-alloyed	<950	130	0.025	0.04	0.055	0.065	0.075	0.1	0.13	0.18	0.22
2.3-2.4	Steel, low-alloyed	<1300	115	0.02	0.035	0.05	0.06	0.07	0.09	0.12	0.17	0.21
3.1-3.2	Steel, high-alloyed	<1100	125	0.02	0.035	0.05	0.06	0.07	0.09	0.12	0.17	0.21
3.3	Steel, high-alloyed	<1400	105	0.018	0.03	0.048	0.058	0.068	0.085	0.11	0.16	0.2
K			Vc (m/min)									
1.1-1.2	Grey cast iron	<1000	170	0.025	0.04	0.055	0.065	0.075	0.1	0.13	0.18	0.22
2.1-2.2	Modular cast iron	<850	140	0.02	0.035	0.05	0.06	0.07	0.09	0.12	0.17	0.21
3.1-3.2	Malleable cast iron	<800	120	0.02	0.035	0.05	0.06	0.07	0.09	0.12	0.17	0.21
M			Vc (m/min)									
1.1	Inox, ferritic/martensitic	<850	100	0.025	0.04	0.055	0.065	0.075	0.1	0.13	0.18	0.22
2.1	Inox, austenitic	<650	90	0.02	0.035	0.05	0.06	0.07	0.09	0.12	0.16	0.2
2.2	Inox, austenitic	<750	80	0.018	0.032	0.045	0.055	0.065	0.08	0.11	0.15	0.18
3.1	Duplex steel	<1100										

NOTE | The values marked in turquoise are side applications!

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