Cooling	
Tolerance	f8
Coating	AlphaFerro Platin X

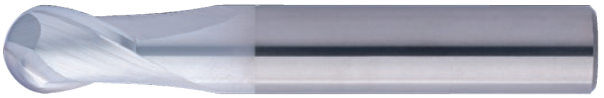
Strategy	HSC
Application	
Features	HA

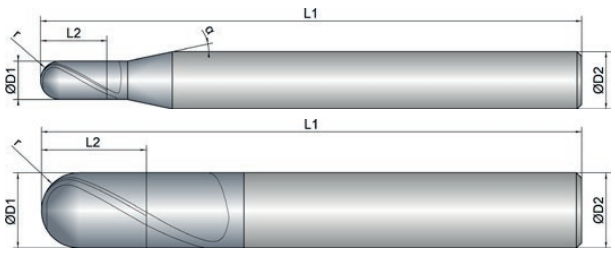
Expert

- Optimized cross cutting edge for minimal face wear
- Innovative shape of the chip chamber for effective chip evacuation
- Defined microbevel for support and stabilization

- For use in HSC milling
- For roughing and finishing

- Designed for use with cooling lubricant
- Radius tolerance r ≤ 2 mm: ± 0.003 mm
- Radius tolerance r > 2 mm: ± 0.005 mm





Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M08-0003	D1 mm ⌀	L2 mm	L1 mm	D2 mm ⌀	z #	r mm	°	α °
0,5	0.5	1.5	57.0	6.0	2	0.25	30	12
1	1.0	2.0	57.0	6.0	2	0.50	30	12
1,5	1.5	3.0	57.0	6.0	2	0.75	30	12
2	2.0	4.0	57.0	6.0	2	1.00	30	12
2,5	2.5	5.0	57.0	6.0	2	1.25	30	12
3	3.0	6.0	57.0	6.0	2	1.50	30	12
4	4.0	7.0	57.0	6.0	2	2.00	30	12
5	5.0	8.0	57.0	6.0	2	2.50	30	12
6	6.0	10.0	57.0	6.0	2	3.00	30	0
8	8.0	12.0	63.0	8.0	2	4.00	30	0
10	10.0	14.0	72.0	10.0	2	5.00	30	0
12	12.0	16.0	83.0	12.0	2	6.00	30	0

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	Material	Strength (N/mm²)	Dimension	Ø0.5	Ø1	Ø1.5	Ø2	Ø2.5	Ø3	Ø4	Ø5	Ø6	Ø8
			Infeed in mm	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD
			Application										
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
P			**Vc (m/min)**										
1.1	Steel, unalloyed	<500	340	0.012	0.025	0.03	0.045	0.05	0.055	0.065	0.075	0.09	0.14
1.2-1.5	Steel, unalloyed	<1100	300	0.01	0.02	0.025	0.04	0.045	0.05	0.06	0.07	0.085	0.12
2.1-2.2	Steel, low-alloyed	<950	280	0.01	0.02	0.025	0.04	0.045	0.05	0.06	0.07	0.085	0.12
2.3-2.4	Steel, low-alloyed	<1300	240	0.008	0.015	0.02	0.035	0.04	0.045	0.055	0.065	0.08	0.11
3.1-3.2	Steel, high-alloyed	<1100	270	0.008	0.015	0.02	0.035	0.04	0.045	0.055	0.065	0.08	0.11
3.3	Steel, high-alloyed	<1400	230	0.006	0.012	0.015	0.03	0.035	0.04	0.05	0.06	0.075	0.09
K			**Vc (m/min)**										
1.1-1.2	Grey cast iron	<1000	350	0.01	0.02	0.025	0.04	0.045	0.05	0.06	0.07	0.085	0.12
2.1-2.2	Modular cast iron	<850	300	0.008	0.015	0.02	0.035	0.04	0.045	0.055	0.065	0.08	0.11
3.1-3.2	Malleable cast iron	<800	260	0.008	0.015	0.02	0.035	0.04	0.045	0.055	0.065	0.08	0.11
M			**Vc (m/min)**										
1.1	Inox, ferritic/martensitic	<850	110	0.01	0.015	0.02	0.025	0.03	0.035	0.045	0.05	0.06	0.075
2.1	Inox, austenitic	<650	90	0.008	0.012	0.015	0.02	0.025	0.03	0.04	0.045	0.055	0.07
2.2	Inox, austenitic	<750	80	0.008	0.012	0.015	0.02	0.025	0.03	0.04	0.045	0.055	0.07
3.1	Duplex steel	<1100											

	Material	Strength (N/mm²)	Dimension	Ø10	Ø12
			Infeed in mm	ae= 0.05xD ap= 0.05xD	ae= 0.05xD ap= 0.05xD
			Application		
			Feed (mm/Z)	fz	fz
P			**Vc (m/min)**		
1.1	Steel, unalloyed	<500	340	0.15	0.16
1.2-1.5	Steel, unalloyed	<1100	300	0.13	0.14
2.1-2.2	Steel, low-alloyed	<950	280	0.13	0.14
2.3-2.4	Steel, low-alloyed	<1300	240	0.12	0.13
3.1-3.2	Steel, high-alloyed	<1100	270	0.12	0.13
3.3	Steel, high-alloyed	<1400	230	0.1	0.11
K			**Vc (m/min)**		
1.1-1.2	Grey cast iron	<1000	350	0.13	0.14
2.1-2.2	Modular cast iron	<850	300	0.12	0.13
3.1-3.2	Malleable cast iron	<800	260	0.12	0.13
M			**Vc (m/min)**		
1.1	Inox, ferritic/martensitic	<850	110	0.09	0.1
2.1	Inox, austenitic	<650	90	0.08	0.09
2.2	Inox, austenitic	<750	80	0.08	0.09
3.1	Duplex steel	<1100			

NOTE | The values marked in turquoise are side applications!