

Cooling	
Tolerance	f8
Coating	AlphaFerro Platin X

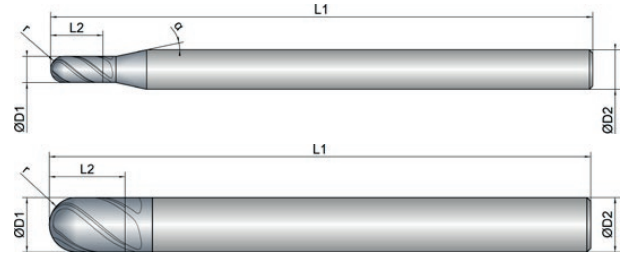
Strategy	<b>HSC</b>
Application	
Features	<b>HA</b>



- Highest surface quality through 4 cutting edges to the center
- Defined tool flank for support and vibration reduction
- Special face geometry for optimal chip evacuation

- For use in HSC milling
- For roughing and finishing

- 4 cutting edges for the highest feed speeds
- Radius tolerance  $r \leq 2$  mm:  $\pm 0.003$  mm
- Radius tolerance  $r > 2$  mm:  $\pm 0.005$  mm



**Roughing**











**Finishing**



EXPK1-M08-0223	D1 mm $\varnothing$	L2 mm	L1 mm	D2 mm $\varnothing$	z #	r mm	$\beta$ °
3	3.0	5.0	83.0	6.0	4	1.50	40
4	4.0	8.0	83.0	6.0	4	2.00	40
5	5.0	9.0	83.0	6.0	4	2.50	40
6	6.0	10.0	83.0	6.0	4	3.00	40
8	8.0	12.0	100.0	8.0	4	4.00	40
10	10.0	14.0	100.0	10.0	4	5.00	40
12	12.0	16.0	100.0	12.0	4	6.00	40
16	16.0	22.0	125.0	16.0	4	8.00	40



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Dimension	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø16		
Infeed in mm	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD		
Application	ap=0.05xD	ap=0.05xD	ap=0.05xD	ap=0.05xD	ap=0.05xD	ap=0.05xD	ap=0.05xD	ap=0.05xD		
										

Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	
<b>P</b>											
Vc (m/min)											
1.1	Steel, unalloyed	<500	280	0.035	0.045	0.05	0.06	0.075	0.09	0.1	0.14
1.2-1.5	Steel, unalloyed	<1100	240	0.03	0.04	0.045	0.055	0.07	0.08	0.09	0.13
2.1-2.2	Steel, low-alloyed	<950	220	0.03	0.04	0.045	0.055	0.07	0.08	0.09	0.13
2.3-2.4	Steel, low-alloyed	<1300	180	0.025	0.035	0.04	0.05	0.065	0.07	0.08	0.12
3.1-3.2	Steel, high-alloyed	<1100	210	0.025	0.035	0.04	0.05	0.065	0.07	0.08	0.12
3.3	Steel, high-alloyed	<1400	170	0.022	0.032	0.038	0.048	0.062	0.065	0.07	0.11
<b>K</b>											
Vc (m/min)											
1.1-1.2	Grey cast iron	<1000	290	0.03	0.04	0.045	0.055	0.07	0.08	0.09	0.13
2.1-2.2	Modular cast iron	<850	240	0.025	0.035	0.04	0.05	0.065	0.07	0.08	0.12
3.1-3.2	Malleable cast iron	<800	200	0.025	0.035	0.04	0.05	0.065	0.07	0.08	0.12
<b>M</b>											
Vc (m/min)											
1.1	Inox, ferritic/martensitic	<850	90	0.03	0.04	0.045	0.055	0.07	0.08	0.09	0.12
2.1	Inox, austenitic	<650	80	0.025	0.035	0.04	0.05	0.065	0.07	0.08	0.11
2.2	Inox, austenitic	<750	70	0.025	0.035	0.04	0.05	0.065	0.07	0.08	0.11
3.1	Duplex steel	<1100									

**NOTE** | The values marked in turquoise are side applications!