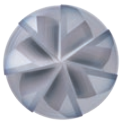
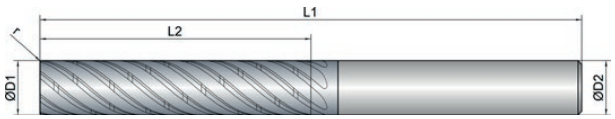
Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	ETC
Application	
Features	HA, ≠, 5xD

Expert

- Variable helical pitch with unequal tooth pitch for smooth running and a soft cut
- Adapted chip chambers for trochoidal milling
- Optimized design of the chip breakers for maximum tool life





- For roughing and finishing under ETC conditions

- 7 cutting edges for best performance with a unique tool life
- Ideal chip evacuation at the highest feed rates

Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M03-0233	D1 mm ⌀	L2 mm	L1 mm	D2 mm ⌀	z #	r mm	°
8	8.0	40.0	90.0	8.0	7	0.20	40
10	10.0	50.0	100.0	10.0	7	0.20	40
12	12.0	60.0	119.0	12.0	7	0.20	40
16	16.0	80.0	134.0	16.0	7	0.30	40
20	20.0	100.0	160.0	20.0	7	0.30	40

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	Material	Strength (N/mm²)	Dimension	Ø 8	Ø 10	Ø 12	Ø 16	Ø 20
			Infeed in mm	ae= 0.03xD ap= Lmax	ae= 0.03xD ap= Lmax	ae= 0.03xD ap= Lmax	ae= 0.03xD ap= Lmax	ae= 0.03xD ap= Lmax
			Application					
			Feed (mm/Z)	fz	fz	fz	fz	fz
P			**Vc (m/min)**					
1.1	Steel, unalloyed	<500	310	0.077	0.09	0.11	0.135	0.16
1.2-1.5	Steel, unalloyed	<1100	250	0.072	0.081	0.1	0.125	0.145
2.1-2.2	Steel, low-alloyed	<950	210	0.072	0.081	0.1	0.125	0.145
2.3-2.4	Steel, low-alloyed	<1300	160	0.068	0.077	0.09	0.115	0.125
3.1-3.2	Steel, high-alloyed	<1100	180	0.068	0.077	0.09	0.115	0.125
3.3	Steel, high-alloyed	<1400	150	0.063	0.072	0.081	0.11	0.12
K			**Vc (m/min)**					
1.1-1.2	Grey cast iron	<1000	235	0.072	0.081	0.1	0.125	0.145
2.1-2.2	Modular cast iron	<850	190	0.068	0.077	0.09	0.115	0.125
3.1-3.2	Malleable cast iron	<800	170	0.063	0.072	0.081	0.11	0.12
M			**Vc (m/min)**					
1.1	Inox, ferritic/martensitic	<850	160	0.059	0.072	0.081	0.11	0.135
2.1	Inox, austenitic	<650	140	0.054	0.063	0.072	0.1	0.125
2.2	Inox, austenitic	<750	120	0.05	0.059	0.063	0.09	0.115
3.1	Duplex steel	<1100						

NOTE | The values marked in turquoise are side applications! We recommend the use of HB shank and side lock arbor. (EXPK1-M03-0234) Values for ETC-milling; please reduce Vc and fz by 20% using trimming.