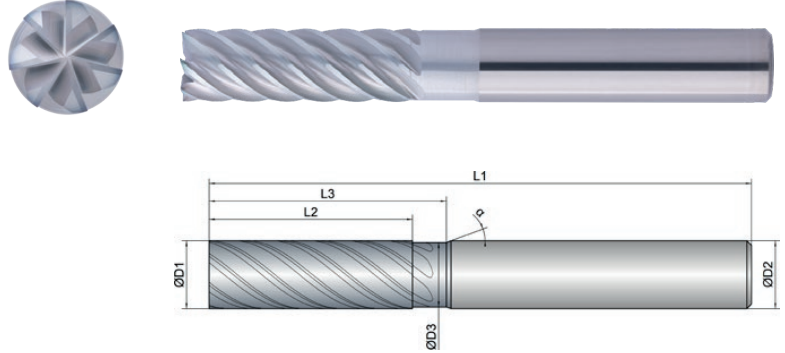


Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	HPC
Application	
Features	HA \neq 3xD



- 7 finely finished and homogenized cutting edges
 - Special groove profile for the removal of long chips
 - Variable helical pitch and unequal tooth pitch for maximum smoothness
-
- For excellent surfaces and maximum dimensional accuracy
-
- 7 cutting edges for highest feed rates



Roughing					Finishing				

	D1	D3	L2	L3	L1	D2	z	α	
EXPK1-M04-0033	 mm \varnothing	 mm \varnothing	 mm	 mm	 mm	 mm \varnothing	 #	 °	 °
6	6.0	5.8	18.0	25.0	63.0	6.0	7	39	20
8	8.0	7.8	24.0	30.0	70.0	8.0	7	39	20
10	10.0	9.5	30.0	35.0	80.0	10.0	7	39	20
12	12.0	11.5	36.0	45.0	93.0	12.0	7	39	20
16	16.0	15.5	48.0	55.0	110.0	16.0	7	39	20
20	20.0	19.5	60.0	70.0	125.0	20.0	7	39	20



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Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20						
Infeed in mm	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD	ae=0.05xD						
Application	ap=Lmax	ap=Lmax	ap=Lmax	ap=Lmax	ap=Lmax	ap=Lmax						

Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz
P									
Vc (m/min)									
1.1	Steel, unalloyed	<500	300	0.03	0.032	0.034	0.036	0.038	0.04
1.2-1.5	Steel, unalloyed	<1100	260	0.03	0.032	0.034	0.036	0.038	0.04
2.1-2.2	Steel, low-alloyed	<950	240	0.028	0.03	0.032	0.034	0.036	0.038
2.3-2.4	Steel, low-alloyed	<1300	220	0.028	0.03	0.032	0.034	0.036	0.038
3.1-3.2	Steel, high-alloyed	<1100	230	0.025	0.027	0.029	0.031	0.033	0.035
3.3	Steel, high-alloyed	<1400	200	0.025	0.027	0.029	0.031	0.033	0.035
K									
Vc (m/min)									
1.1-1.2	Grey cast iron	<1000	240	0.028	0.03	0.032	0.034	0.036	0.038
2.1-2.2	Modular cast iron	<850	220	0.025	0.027	0.029	0.031	0.033	0.035
3.1-3.2	Malleable cast iron	<800	200	0.025	0.027	0.029	0.031	0.033	0.035
M									
Vc (m/min)									
1.1	Inox, ferritic/martensitic	<850	140	0.028	0.03	0.032	0.034	0.036	0.038
2.1	Inox, austenitic	<650	120	0.026	0.028	0.03	0.032	0.034	0.036
2.2	Inox, austenitic	<750	100	0.024	0.026	0.028	0.03	0.032	0.034
3.1	Duplex steel	<1100							

NOTE | The values marked in turquoise are side applications! To achieve high surface quality, use ae=0.2 mm for Ø6-10; ae=0.3mm for Ø12-20.

STILL CAN'T FIND A SUITABLE MILLING CUTTER?

No problem – simply customize an existing tool. Using our configurator for special milling cutters, you can customize existing tools to your needs in an instant or create your own tools based on predefined types.



WE WILL RESPOND TO ALL REQUESTS SUBMITTED VIA THE CONFIGURATOR WITHIN ONE WORKING DAY AT THE LATEST

