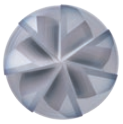
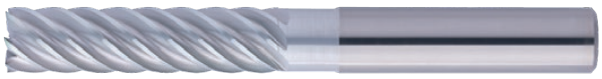
Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	HPC
Application	
Features	HA, ≠, 4xD

Expert

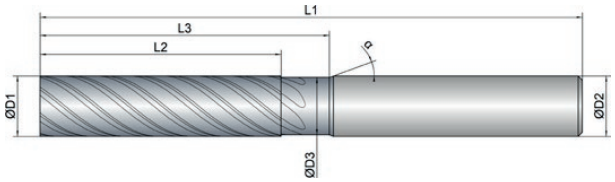
- 7 finely finished and homogenized cutting edges
- Special groove profile for the removal of long chips
- Variable helical pitch and unequal tooth pitch for maximum smoothness





- For excellent surfaces and maximum dimensional accuracy

- 7 cutting edges for highest feed rates



Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M04-0043	D1 mm ⌀	D3 mm ⌀	L2 mm	L3 mm	L1 mm	D2 mm ⌀	z #		α °
6	6.0	5.8	24.0	32.0	63.0	6.0	7	39	20
8	8.0	7.8	32.0	40.0	80.0	8.0	7	39	20
10	10.0	9.5	40.0	48.0	90.0	10.0	7	39	20
12	12.0	11.5	48.0	56.0	100.0	12.0	7	39	20
16	16.0	15.5	64.0	72.0	125.0	16.0	7	39	20
20	20.0	19.5	80.0	88.0	150.0	20.0	7	39	20

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	Material	Strength (N/mm²)	Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
			Infeed in mm	ae= 0.05xD ap= Lmax	ae= 0.05xD ap= Lmax	ae= 0.05xD ap= Lmax	ae= 0.05xD ap= Lmax	ae= 0.05xD ap= Lmax	ae= 0.05xD ap= Lmax
			Application						
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz
P			**Vc (m/min)**						
1.1	Steel, unalloyed	<500	260	0.03	0.032	0.034	0.036	0.038	0.04
1.2-1.5	Steel, unalloyed	<1100	220	0.03	0.032	0.034	0.036	0.038	0.04
2.1-2.2	Steel, low-alloyed	<950	200	0.028	0.03	0.032	0.034	0.036	0.038
2.3-2.4	Steel, low-alloyed	<1300	180	0.028	0.03	0.032	0.034	0.036	0.038
3.1-3.2	Steel, high-alloyed	<1100	190	0.025	0.027	0.029	0.031	0.033	0.035
3.3	Steel, high-alloyed	<1400	160	0.025	0.027	0.029	0.031	0.033	0.035
K			**Vc (m/min)**						
1.1-1.2	Grey cast iron	<1000	200	0.028	0.03	0.032	0.034	0.036	0.038
2.1-2.2	Modular cast iron	<850	180	0.025	0.027	0.029	0.031	0.033	0.035
3.1-3.2	Malleable cast iron	<800	160	0.025	0.027	0.029	0.031	0.033	0.035
M			**Vc (m/min)**						
1.1	Inox, ferritic/martensitic	<850	120	0.028	0.03	0.032	0.034	0.036	0.038
2.1	Inox, austenitic	<650	100	0.026	0.028	0.03	0.032	0.034	0.036
2.2	Inox, austenitic	<750	80	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 Ø 6–10; ae = 0.3mm for Ø 12–20.