

Cooling

Tolerance e8

Coating AlphaFerro Platin X

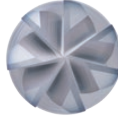
Strategy HPC

Application

Features HA ≠ 5xD

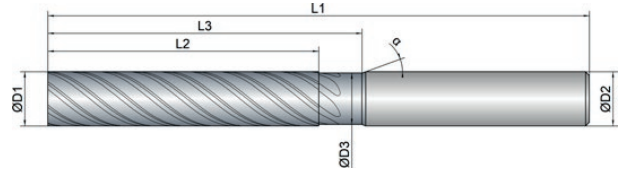


- 7 finely finished and homogenized cutting edges
- Special groove profile for the removal of long chips
- Variable helical pitch and unequal tooth pitch for maximum smoothness

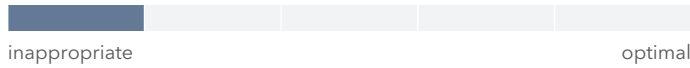


- For excellent surfaces and maximum dimensional accuracy

- 7 cutting edges for highest feed rates



**Roughing**



**Finishing**



EXPK1-M04-0053	D1  mm ∅	D3  mm ∅	L2  mm	L3  mm	L1  mm	D2  mm ∅	z  #	 °	α  °
6	6.0	5.8	30.0	38.0	75.0	6.0	7	39	20
8	8.0	7.8	40.0	48.0	80.0	8.0	7	39	20
10	10.0	9.5	50.0	58.0	100.0	10.0	7	39	20
12	12.0	11.5	60.0	68.0	119.0	12.0	7	39	20
16	16.0	15.5	80.0	88.0	134.0	16.0	7	39	20
20	20.0	19.5	100.0	108.0	175.0	20.0	7	39	20



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		Dimension	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20						
		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	ae=0.03xD ap=Lmax						
		Application												
Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz					
<b>P</b>		<b>Vc (m/min)</b>												
1.1	Steel, unalloyed	<500	260	0.026	0.028	0.03	0.032	0.034	0.036					
1.2-1.5	Steel, unalloyed	<1100	220	0.026	0.028	0.03	0.032	0.034	0.036					
2.1-2.2	Steel, low-alloyed	<950	200	0.024	0.026	0.028	0.03	0.032	0.034					
2.3-2.4	Steel, low-alloyed	<1300	180	0.024	0.026	0.028	0.03	0.032	0.034					
3.1-3.2	Steel, high-alloyed	<1100	190	0.021	0.023	0.025	0.027	0.03	0.032					
3.3	Steel, high-alloyed	<1400	160	0.021	0.023	0.025	0.027	0.03	0.032					
<b>K</b>		<b>Vc (m/min)</b>												
1.1-1.2	Grey cast iron	<1000	200	0.024	0.026	0.028	0.03	0.032	0.034					
2.1-2.2	Modular cast iron	<850	180	0.021	0.023	0.025	0.027	0.03	0.032					
3.1-3.2	Malleable cast iron	<800	160	0.021	0.023	0.025	0.027	0.03	0.032					
<b>M</b>		<b>Vc (m/min)</b>												
1.1	Inox, ferritic/martensitic	<850	120	0.024	0.026	0.028	0.03	0.032	0.034					
2.1	Inox, austenitic	<650	100	0.022	0.024	0.026	0.028	0.03	0.032					
2.2	Inox, austenitic	<750	80	0.02	0.022	0.024	0.026	0.028	0.03					
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

