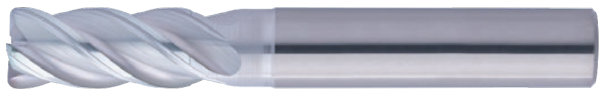
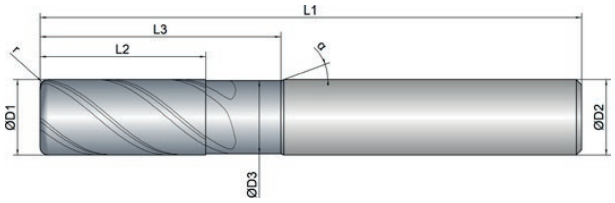
Cooling	
Tolerance	e8
Coating	AlphaFerro Platin X

Strategy	HSC, HPC
Application	
Features	HA

Expert

- Unequal tooth pitch and variable helical pitch for smooth running
- Specially designed cutting edge geometry for contour machining
- Optimized chip chambers for safe evacuation of the chips





- For roughing and finishing, up to 1xD full slot
- Multipass milling of 3D contours

- Radius tolerance r ≤ 1.5 mm: ± 0.003 mm
- Radius tolerance r > 1.5 mm: ± 0.005 mm

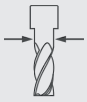
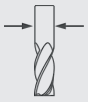
Roughing

inappropriate — optimal

Finishing

inappropriate — optimal

EXPK1-M06-0123	D1 mm ø	D3 mm ø	L2 mm	L3 mm	L1 mm	D2 mm ø	z #	r mm	°	α °
6/0,5	6.0	5.8	13.0	20.0	57.0	6.0	4	0.50	40	20
6/1	6.0	5.8	13.0	20.0	57.0	6.0	4	1.00	40	20
6/1,5	6.0	5.8	13.0	20.0	57.0	6.0	4	1.50	40	20
8/0,5	8.0	7.7	19.0	25.0	63.0	8.0	4	0.50	40	20
8/1	8.0	7.7	19.0	25.0	63.0	8.0	4	1.00	40	20
8/2	8.0	7.7	19.0	25.0	63.0	8.0	4	2.00	40	20
8/3	8.0	7.7	19.0	25.0	63.0	8.0	4	3.00	40	20
10/0,5	10.0	9.7	22.0	32.0	72.0	10.0	4	0.50	40	20
10/1	10.0	9.7	22.0	32.0	72.0	10.0	4	1.00	40	20
10/2	10.0	9.7	22.0	32.0	72.0	10.0	4	2.00	40	20
10/3	10.0	9.7	22.0	32.0	72.0	10.0	4	3.00	40	20

EXPK1-M06-0123	D1  mm ø	D3  mm ø	L2  mm	L3  mm	L1  mm	D2  mm ø	z  #	r  mm	 °	α  °
12/0,5	12.0	11.6	26.0	38.0	83.0	12.0	4	0.50	40	20
12/1	12.0	11.6	26.0	38.0	83.0	12.0	4	1.00	40	20
12/2	12.0	11.6	26.0	38.0	83.0	12.0	4	2.00	40	20
12/3	12.0	11.6	26.0	38.0	83.0	12.0	4	3.00	40	20
16/0,5	16.0	15.5	32.0	44.0	92.0	16.0	4	0.50	40	20
16/1	16.0	15.5	32.0	44.0	92.0	16.0	4	1.00	40	20
16/2	16.0	15.5	32.0	44.0	92.0	16.0	4	2.00	40	20
16/3	16.0	15.5	32.0	44.0	92.0	16.0	4	3.00	40	20
20/1	20.0	19.5	41.0	54.0	104.0	20.0	4	1.00	40	20
20/2	20.0	19.5	41.0	54.0	104.0	20.0	4	2.00	40	20
20/3	20.0	19.5	41.0	54.0	104.0	20.0	4	3.00	40	20
20/4	20.0	19.5	41.0	54.0	104.0	20.0	4	4.00	40	20

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			Dimension	Ø6			Ø8			Ø10			Ø12		
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ae= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ae= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ae= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ae= 0.04xD
			Application												
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
P			Vc (m/min)												
1.1	Steel, unalloyed	<500	240	0.04	0.045	0.05	0.05	0.055	0.065	0.055	0.06	0.075	0.06	0.065	0.085
1.2-1.5	Steel, unalloyed	<1100	200	0.035	0.04	0.045	0.045	0.05	0.06	0.05	0.055	0.07	0.055	0.06	0.08
2.1-2.2	Steel, low-alloyed	<950	190	0.035	0.04	0.045	0.045	0.05	0.06	0.05	0.055	0.07	0.055	0.06	0.08
2.3-2.4	Steel, low-alloyed	<1300	160	0.03	0.035	0.04	0.04	0.045	0.055	0.045	0.05	0.065	0.05	0.055	0.075
3.1-3.2	Steel, high-alloyed	<1100	180	0.03	0.035	0.04	0.04	0.045	0.055	0.045	0.05	0.065	0.05	0.055	0.075
3.3	Steel, high-alloyed	<1400	150	0.028	0.032	0.038	0.038	0.042	0.052	0.042	0.045	0.06	0.045	0.05	0.07
K			Vc (m/min)												
1.1-1.2	Grey cast iron	<1000	220	0.035	0.04	0.045	0.045	0.05	0.06	0.05	0.055	0.07	0.055	0.06	0.08
2.1-2.2	Modular cast iron	<850	180	0.03	0.035	0.04	0.04	0.045	0.055	0.045	0.05	0.065	0.05	0.055	0.075
3.1-3.2	Malleable cast iron	<800	160	0.03	0.035	0.04	0.04	0.045	0.055	0.045	0.05	0.065	0.05	0.055	0.075
M			Vc (m/min)												
1.1	Inox, ferritic/martensitic	<850	90		0.035	0.04		0.045	0.055		0.05	0.065		0.055	0.075
2.1	Inox, austenitic	<650	75		0.03	0.035		0.04	0.05		0.045	0.06		0.05	0.07
2.2	Inox, austenitic	<750	70		0.028	0.032		0.038	0.048		0.042	0.058		0.048	0.068
3.1	Duplex steel	<1100													

			Dimension	Ø16			Ø20		
			Infeed in mm	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ae= 0.04xD	ae= 1xD ap= 1xD	ae= 0.3xD ap= 1xD	ae= 0.04xD ae= 0.04xD
			Application						
	Material	Strength (N/mm²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz
P			Vc (m/min)						
1.1	Steel, unalloyed	<500	240	0.07	0.08	0.1	0.09	0.1	0.12
1.2-1.5	Steel, unalloyed	<1100	200	0.06	0.07	0.09	0.08	0.09	0.11
2.1-2.2	Steel, low-alloyed	<950	190	0.06	0.07	0.09	0.08	0.09	0.11
2.3-2.4	Steel, low-alloyed	<1300	160	0.05	0.06	0.08	0.07	0.08	0.1
3.1-3.2	Steel, high-alloyed	<1100	180	0.05	0.06	0.08	0.07	0.08	0.1
3.3	Steel, high-alloyed	<1400	150	0.045	0.055	0.075	0.065	0.075	0.09
K			Vc (m/min)						
1.1-1.2	Grey cast iron	<1000	220	0.06	0.08	0.09	0.08	0.09	0.11
2.1-2.2	Modular cast iron	<850	180	0.05	0.07	0.08	0.07	0.08	0.1
3.1-3.2	Malleable cast iron	<800	160	0.05	0.07	0.08	0.07	0.08	0.1
M			Vc (m/min)						
1.1	Inox, ferritic/martensitic	<850	90		0.08	0.1		0.1	0.12
2.1	Inox, austenitic	<650	75		0.075	0.09		0.09	0.11
2.2	Inox, austenitic	<750	70		0.072	0.085		0.085	0.1
3.1	Duplex steel	<1100							

NOTE | The values marked in turquoise are side applications! By using multipass milling the maximum infeed (ae, ap) is 0.5xcorner radius!