




Cooling 

Tolerance f8

Coating AlphaFerro Platin X

Strategy **HSC**

Application 

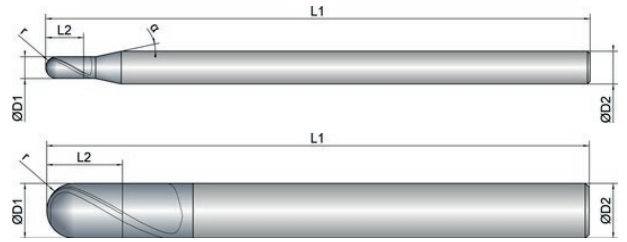
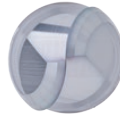
Features **HA** 



Expert



- Optimized cross cutting edge for minimal face wear
 - Innovative shape of the chip chamber for effective chip evacuation
 - Defined microbevel for support and stabilization
-
- For use in HSC milling
 - For roughing and finishing
 - Overlong version for deepest cavities
-
- Designed for use with cooling lubricant
 - Radius tolerance $r \leq 2 \text{ mm}$: $\pm 0.003 \text{ mm}$
 - Radius tolerance $r > 2 \text{ mm}$: $\pm 0.005 \text{ mm}$




Roughing













Finishing




EXPK1-M08-0023	D1 mm ∅	L2 mm	L1 mm	D2 mm ∅	z #	r mm		α °
1	1.0	2.0	100.0	6.0	2	0.50	30	12
1,5	1.5	3.0	100.0	6.0	2	0.75	30	12
2	2.0	4.0	100.0	6.0	2	1.00	30	12
2,5	2.5	5.0	100.0	6.0	2	1.25	30	12
3	3.0	6.0	100.0	6.0	2	1.50	30	12
4	4.0	7.0	100.0	6.0	2	2.00	30	12
5	5.0	8.0	100.0	6.0	2	2.50	30	12
6	6.0	10.0	100.0	6.0	2	3.00	30	0
8	8.0	12.0	100.0	8.0	2	4.00	30	0
10	10.0	14.0	100.0	10.0	2	5.00	30	0
12	12.0	16.0	120.0	12.0	2	6.00	30	0



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		Dimension	Ø1	Ø1.5	Ø2	Ø2.5	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	
		Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	
		Application											
Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
P		Vc (m/min)											
1.1	Steel, unalloyed	<500	300	0.02	0.03	0.04	0.045	0.05	0.06	0.07	0.08	0.13	0.14
1.2-1.5	Steel, unalloyed	<1100	260	0.015	0.025	0.035	0.04	0.045	0.055	0.065	0.075	0.11	0.12
2.1-2.2	Steel, low-alloyed	<950	240	0.015	0.025	0.035	0.04	0.045	0.055	0.065	0.075	0.11	0.12
2.3-2.4	Steel, low-alloyed	<1300	200	0.012	0.02	0.03	0.035	0.04	0.05	0.06	0.07	0.1	0.11
3.1-3.2	Steel, high-alloyed	<1100	230	0.012	0.02	0.03	0.035	0.04	0.05	0.06	0.07	0.1	0.11
3.3	Steel, high-alloyed	<1400	190	0.01	0.018	0.025	0.03	0.035	0.045	0.055	0.065	0.08	0.09
K		Vc (m/min)											
1.1-1.2	Grey cast iron	<1000	310	0.015	0.025	0.035	0.04	0.045	0.055	0.065	0.075	0.11	0.12
2.1-2.2	Modular cast iron	<850	260	0.012	0.02	0.03	0.035	0.04	0.05	0.06	0.07	0.1	0.11
3.1-3.2	Malleable cast iron	<800	220	0.012	0.02	0.03	0.035	0.04	0.05	0.06	0.07	0.1	0.11
M		Vc (m/min)											
1.1	Inox, ferritic/martensitic	<850	90	0.012	0.018	0.02	0.025	0.03	0.04	0.045	0.055	0.065	0.08
2.1	Inox, austenitic	<650	75	0.01	0.015	0.015	0.02	0.025	0.035	0.04	0.05	0.06	0.07
2.2	Inox, austenitic	<750	65	0.01	0.015	0.015	0.02	0.025	0.035	0.04	0.05	0.06	0.07
3.1	Duplex steel	<1100											

		Dimension	Ø12									
		Infeed in mm	ae=0.05xD ap=0.05xD									
		Application										
Material	Strength (N/mm ²)	Feed (mm/Z)	fz									
P		Vc (m/min)										
1.1	Steel, unalloyed	<500	320	0.15								
1.2-1.5	Steel, unalloyed	<1100	280	0.13								
2.1-2.2	Steel, low-alloyed	<950	260	0.13								
2.3-2.4	Steel, low-alloyed	<1300	220	0.12								
3.1-3.2	Steel, high-alloyed	<1100	250	0.12								
3.3	Steel, high-alloyed	<1400	210	0.1								
K		Vc (m/min)										
1.1-1.2	Grey cast iron	<1000	330	0.13								
2.1-2.2	Modular cast iron	<850	280	0.12								
3.1-3.2	Malleable cast iron	<800	240	0.12								
M		Vc (m/min)										
1.1	Inox, ferritic/martensitic	<850	90	0.09								
2.1	Inox, austenitic	<650	75	0.08								
2.2	Inox, austenitic	<750	65	0.08								
3.1	Duplex steel	<1100										

NOTE | The values marked in turquoise are side applications!