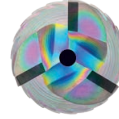




Cooling	
Tolerance	e8
Coating	AlphaSlide Rainbow

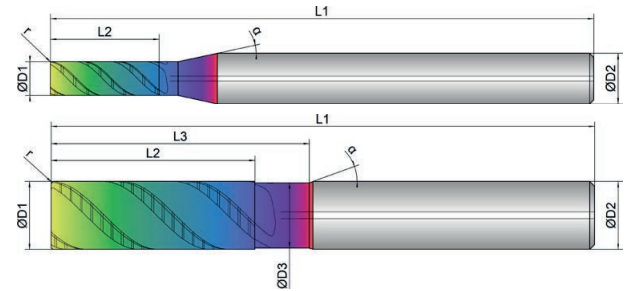
Strategy	ETC	HPC				
Application						
Features	HA	≠				

- Roughing teeth for the smallest chips in volume machining
- Special helical pitch for smooth running and soft cut
- Extra large chip chambers for an extreme chip volume



- For roughing, up to 3xD full slot
- For process reliable, helical diving and immersion

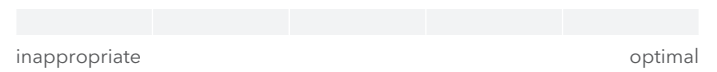
- With central inner cooling
- Also ideally designed for trochoidal milling



Roughing



Finishing



	D1	D3	L2	L3	L1	D2	z	r		α
EXN1-M02-0163	 mm \varnothing	 mm \varnothing	 mm	 mm	 mm	 mm \varnothing	 #	 mm	 °	 °
4	4.0	0.0	13.0	0.0	65.0	6.0	3	0.10	45	12
5	5.0	0.0	16.0	0.0	65.0	6.0	3	0.20	45	12
6	6.0	5.6	18.0	24.0	65.0	6.0	3	0.20	45	20
8	8.0	7.6	24.0	30.0	70.0	8.0	3	0.20	45	20
10	10.0	9.6	30.0	38.0	80.0	10.0	3	0.32	45	20
12	12.0	11.4	36.0	46.0	93.0	12.0	3	0.32	45	20
16	16.0	15.4	48.0	58.0	110.0	16.0	3	0.32	45	20
20	20.0	19.4	60.0	74.0	125.0	20.0	3	0.50	45	20



VEXN1-M02-0163



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Dimension	Ø4		Ø5		Ø6		Ø8		Ø10		Ø12	
Infeed in mm	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD
Application	ap=2xD	ap=3xD	ap=2xD	ap=3xD	ap=2xD	ap=3xD	ap=2xD	ap=3xD	ap=2xD	ap=3xD	ap=2xD	ap=3xD

Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
N		Vc (m/min)													
1.1	Aluminium, alloyed	<500	500	0.03	0.04	0.04	0.06	0.06	0.08	0.08	0.1	0.1	0.12	0.12	0.14
1.2	Aluminium, alloyed	<600	480	0.03	0.04	0.04	0.06	0.06	0.08	0.08	0.1	0.1	0.12	0.12	0.14
2.1-2.3	Aluminium, casted	<600	450	0.025	0.035	0.035	0.055	0.055	0.07	0.07	0.09	0.09	0.11	0.11	0.13
3.1-3.3	Cooper, alloyed	<650	200	0.015	0.025	0.025	0.045	0.045	0.06	0.06	0.08	0.08	0.1	0.1	0.12
4.1	Magnesium, alloyed	<250	500	0.03	0.04	0.04	0.06	0.06	0.08	0.08	0.1	0.1	0.12	0.12	0.14
5.1	Thermoplastic	<100	350	0.025	0.035	0.03	0.045	0.04	0.06	0.05	0.06	0.06	0.08	0.06	0.1
5.2	Duroplastic	<150	300	0.02	0.03	0.025	0.04	0.035	0.055	0.04	0.05	0.05	0.07	0.05	0.09

Dimension	Ø16		Ø20					
Infeed in mm	ae=1xD	ae=0.3xD	ae=1xD	ae=0.3xD				
Application	ap=2xD	ap=3xD	ap=2xD	ap=3xD				

Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	
N		Vc (m/min)					
1.1	Aluminium, alloyed	<500	500	0.13	0.15	0.16	0.2
1.2	Aluminium, alloyed	<600	480	0.13	0.15	0.16	0.2
2.1-2.3	Aluminium, casted	<600	450	0.12	0.14	0.14	0.18
3.1-3.3	Cooper, alloyed	<650	200	0.11	0.13	0.13	0.16
4.1	Magnesium, alloyed	<250	500	0.13	0.15	0.16	0.2
5.1	Thermoplastic	<100	350	0.1	0.13	0.13	0.17
5.2	Duroplastic	<150	300	0.09	0.12	0.12	0.16

NOTE | The values marked in turquoise are side applications!