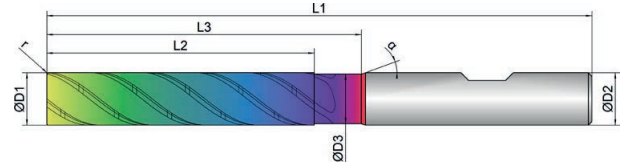
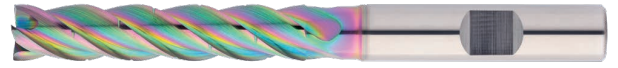
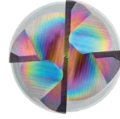




Cooling	
Tolerance	h6
Coating	AlphaSlide Rainbow

Strategy	<b>ETC</b>	
Application		
Features	<b>HB</b> $\neq$	

- Chip breaker for short, defined chip length
  - Unequal tooth pitch combined with variable helical pitch for smooth running
  - Reinforced face with 2 cutting edges to the center
- 
- For roughing and finishing under ETC conditions
  - For process reliable, helical immersion
- 
- Ideal chip evacuation, even with high radial depth of cutting



**Roughing**



**Finishing**



EXN1-M03-0054	D1  mm ∅	D3  mm ∅	L2  mm	L3  mm	L1  mm	D2  mm ∅	z  #	r  mm	 °	$\alpha$  °
10	10.0	9.5	51.0	60.0	104.0	10.0	4	0.20	38	20
12	12.0	11.0	61.0	72.0	120.0	12.0	4	0.20	38	20
16	16.0	15.0	81.0	96.0	150.0	16.0	4	0.30	38	20
20	20.0	19.0	102.0	120.0	175.0	20.0	4	0.30	38	20



Download Catalog Pages (PDF)

Dimension	Ø10	Ø12	Ø16	Ø20						
Infeed in mm	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max	ae= 0.07xD ap= L2 max						
Application										

Material	Strength (N/mm <sup>2</sup> )	Feed (mm/Z)								
		fz	fz	fz	fz					
N		Vc (m/min)								
1.1	Aluminium, alloyed	<500	500	0.08	0.095	0.13	0.16			
1.2	Aluminium, alloyed	<600	480	0.08	0.095	0.13	0.16			
2.1-2.3	Aluminium, casted	<600	460	0.07	0.085	0.12	0.15			
3.1-3.3	Cooper, alloyed	<650	200	0.06	0.075	0.11	0.14			
4.1	Magnesium, alloyed	<250	500	0.08	0.095	0.13	0.16			
5.1	Thermoplastic	<100								
5.2	Duroplastic	<150								