

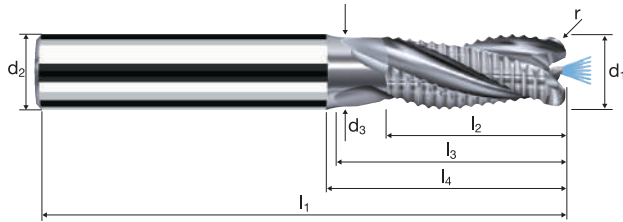
Corner radius end mills AX-FPS (AX-RFPS)



Profiled, normal version with short neck
High-performance penetration edge with central cooling channel

HM λ 30°
MG10 γ 20°

h5 **G2.5**

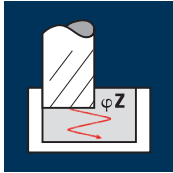
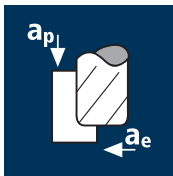


Aluminium > 99% Al Aluminium Alloy Al Aluminium Cast Cu Copper Plastic Thermoplast

Ø Code	d ₁ e8	d ₂ h5	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	z	Example: Order-N°.	
										Coating	Article-N°.
										15502	
498	12.00	12.00	11.00	83	26.00	33.29	37.00	0.500	3	●	ⓘ
606	16.00	16.00	15.00	95	32.00	41.73	46.00	0.500	3	●	ⓘ
501	12.00	12.00	11.00	83	26.00	33.29	37.00	1.000	3	●	ⓘ
608	16.00	16.00	15.00	95	32.00	41.73	46.00	1.000	3	●	ⓘ
680	20.00	20.00	19.00	104	40.00	48.23	53.00	1.000	3	●	ⓘ
770*	25.00	25.00	24.00	121	50.00	64.68	70.00	1.000	3	●	ⓘ
505	12.00	12.00	11.00	83	26.00	33.29	37.00	2.000	3	●	ⓘ
611	16.00	16.00	15.00	95	32.00	41.73	46.00	2.000	3	●	ⓘ
683	20.00	20.00	19.00	104	40.00	48.23	53.00	2.000	3	●	ⓘ
772*	25.00	25.00	24.00	121	50.00	64.68	70.00	2.000	3	●	ⓘ
506	12.00	12.00	11.00	83	26.00	33.29	37.00	2.500	3	●	ⓘ
612	16.00	16.00	15.00	95	32.00	41.73	46.00	2.500	3	●	ⓘ
684	20.00	20.00	19.00	104	40.00	48.23	53.00	2.500	3	●	ⓘ
774*	25.00	25.00	24.00	121	50.00	64.68	70.00	2.500	3	●	ⓘ

* Cylindrical shank HA, shank length = 50 mm
ⓘ Availability and delivery dates on request.

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper

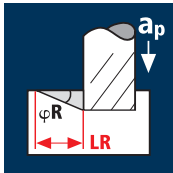
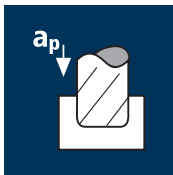


d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φZ [°]
12.00	3	500	0.140	18.000	9.600	13265	5570	962.6	12°
16.00	3	500	0.160	24.000	12.800	9945	4775	1466.8	12°
20.00	3	500	0.180	30.000	16.000	7960	4295	2062.6	12°
25.00	3	500	0.200	37.500	20.000	6365	3820	2864.8	12°

12.00	3	450	0.140	18.000	9.600	11935	5015	866.3	12°
16.00	3	450	0.160	24.000	12.800	8950	4295	1320.1	12°
20.00	3	450	0.180	30.000	16.000	7160	3865	1856.4	12°
25.00	3	450	0.200	37.500	20.000	5730	3440	2578.3	12°

12.00	3	400	0.126	18.000	9.600	10610	4010	693.0	7°
16.00	3	400	0.144	24.000	12.800	7960	3440	1056.1	7°
20.00	3	400	0.162	30.000	16.000	6365	3095	1485.1	7°
25.00	3	400	0.180	37.500	20.000	5095	2750	2062.6	7°

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φR [°]	LR [mm]
12.00	3	450	0.126	18.000	12.000	11935	4510	974.6	15°	67.2
16.00	3	450	0.144	24.000	16.000	8950	3865	1485.1	15°	89.6
20.00	3	450	0.162	30.000	20.000	7160	3480	2088.4	15°	112.0
25.00	3	450	0.180	37.500	25.000	5730	3095	2900.6	15°	140.0

12.00	3	405	0.126	18.000	12.000	10745	4060	877.1	15°	67.2
16.00	3	405	0.144	24.000	16.000	8055	3480	1336.6	15°	89.6
20.00	3	405	0.162	30.000	20.000	6445	3135	1879.6	15°	112.0
25.00	3	405	0.180	37.500	25.000	5155	2785	2610.5	15°	140.0

12.00	3	320	0.101	18.000	12.000	8490	2565	554.4	9°	113.6
16.00	3	320	0.115	24.000	16.000	6365	2200	844.9	9°	151.5
20.00	3	320	0.130	30.000	20.000	5095	1980	1188.1	9°	189.4
25.00	3	320	0.144	37.500	25.000	4075	1760	1650.1	9°	236.8



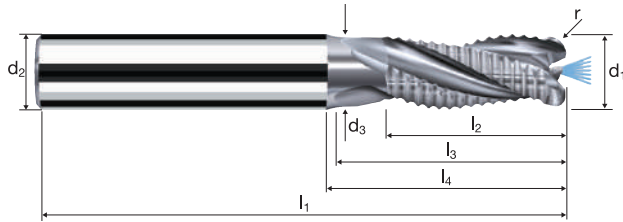
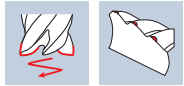
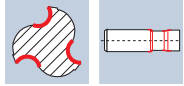
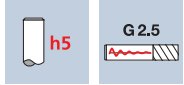
Use
ToolExpert AX-FPS
to determine the best
possible cutting data
for your machining
environment!

Corner radius end mills AX-FPS (AX-RFPS)



Profiled, normal version with short neck
High-performance penetration edge with central cooling channel

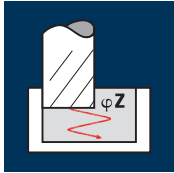
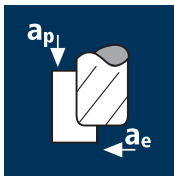
HM
MG10 λ 30°
 γ 20°



			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Ø Code	d ₁ e8	d ₂ h5	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	z	Example: Order-N°.		
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776*	25.00	25.00	24.00	121	50.00	64.68	70.00	4.000	3	●	I	
777*	25.00	25.00	24.00	121	50.00	64.68	70.00	5.000	3	●	I	
* Cylindrical shank HA, shank length = 50 mm												
I Availability and delivery dates on request.												

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper

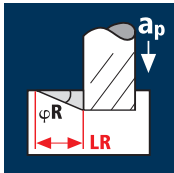
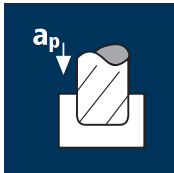


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25.00	3	400	0.180	37.500	20.000	5095	2750	2062.6	7°

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φR [°]	LR [mm]
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20.00	3	320	0.130	30.000	20.000	5095	1980	1188.1	9°	189.4
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