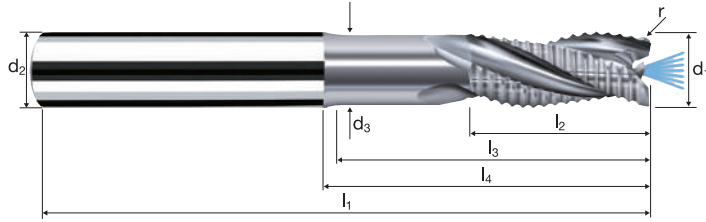


Cylindrical end mills AX-FPS

Profiled, medium length version, neck
High-performance penetration edge, central cooling channel



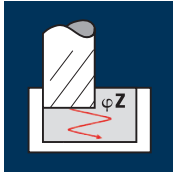
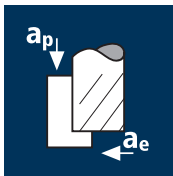
HM MG10	30° 20°
	G 2.5



			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	z	Example: Order-N°.	
										Coating	Article-N°
											15605
											15505
300	6.00	6.00	5.50	63	13.00	24.15	26.00	0.100	3		●
391	8.00	8.00	7.40	72	18.00	32.63	35.00	0.150	3		●
450	10.00	10.00	9.20	84	22.00	39.99	43.00	0.200	3		●
501	12.00	12.00	11.00	97	26.00	47.29	51.00	0.200	3		●
610	16.00	16.00	15.00	108	32.00	54.73	59.00	0.200	3		●
682	20.00	20.00	19.00	122	40.00	66.23	71.00	0.200	3		●
770**	25.00	25.00	24.00	144	50.00	81.68	87.00	0.250	3		●
772*	25.00	25.00	24.00	144	50.00	86.68	92.00	0.250	3		●
* Cylindrical shank HA, shank length = 50 mm											
** Shank with side clamping according to DIN 6535 HB											

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper

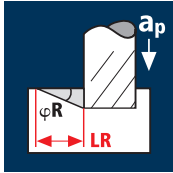


d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	Z [°]
6.00	3	450	0.064	9.000	3.600	23875	4585	148.5	15°
8.00	3	450	0.080	12.000	4.800	17905	4295	247.5	15°
10.00	3	450	0.096	15.000	6.000	14325	4125	371.3	15°
12.00	3	450	0.112	18.000	7.200	11935	4010	519.8	15°
16.00	3	450	0.128	24.000	9.600	8950	3440	792.1	15°
20.00	3	450	0.144	30.000	12.000	7160	3095	1113.8	15°
25.00	3	450	0.160	37.500	15.000	5730	2750	1547.0	15°

6.00	3	405	0.064	9.000	3.600	21485	4125	133.7	15°
8.00	3	405	0.080	12.000	4.800	16115	3865	222.8	15°
10.00	3	405	0.096	15.000	6.000	12890	3715	334.1	15°
12.00	3	405	0.112	18.000	7.200	10745	3610	467.8	15°
16.00	3	405	0.128	24.000	9.600	8055	3095	712.9	15°
20.00	3	405	0.144	30.000	12.000	6445	2785	1002.4	15°
25.00	3	405	0.160	37.500	15.000	5155	2475	1392.3	15°

6.00	3	360	0.058	9.000	3.600	19100	3300	106.9	9°
8.00	3	360	0.072	12.000	4.800	14325	3095	178.2	9°
10.00	3	360	0.086	15.000	6.000	11460	2970	267.3	9°
12.00	3	360	0.101	18.000	7.200	9550	2890	374.2	9°
16.00	3	360	0.115	24.000	9.600	7160	2475	570.3	9°
20.00	3	360	0.130	30.000	12.000	5730	2230	802.0	9°
25.00	3	360	0.144	37.500	15.000	4585	1980	1113.8	9°

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	R [°]	LR [mm]
6.00	3	315	0.051	9.000	6.000	16710	2565	138.6	15°	33.6
8.00	3	315	0.064	12.000	8.000	12535	2405	231.0	15°	44.8
10.00	3	315	0.077	15.000	10.000	10025	2310	346.5	15°	56.0
12.00	3	315	0.090	18.000	12.000	8355	2245	485.1	15°	67.2
16.00	3	315	0.102	24.000	16.000	6265	1925	739.3	15°	89.6
20.00	3	315	0.115	30.000	20.000	5015	1735	1039.6	15°	112.0
25.00	3	315	0.128	37.500	25.000	4010	1540	1443.9	15°	140.0

6.00	3	285	0.051	9.000	6.000	15120	2320	125.4	15°	33.6
8.00	3	285	0.064	12.000	8.000	11340	2175	209.0	15°	44.8
10.00	3	285	0.077	15.000	10.000	9070	2090	313.5	15°	56.0
12.00	3	285	0.090	18.000	12.000	7560	2030	438.9	15°	67.2
16.00	3	285	0.102	24.000	16.000	5670	1740	668.8	15°	89.6
20.00	3	285	0.115	30.000	20.000	4535	1570	940.6	15°	112.0
25.00	3	285	0.128	37.500	25.000	3630	1395	1306.3	15°	140.0

6.00	3	216	0.040	9.000	6.000	11460	1385	74.8	9°	56.8
8.00	3	216	0.050	12.000	8.000	8595	1300	124.7	9°	75.8
10.00	3	216	0.060	15.000	10.000	6875	1245	187.1	9°	94.7
12.00	3	216	0.071	18.000	12.000	5730	1215	262.0	9°	113.6
16.00	3	216	0.081	24.000	16.000	4295	1040	399.2	9°	151.5
20.00	3	216	0.091	30.000	20.000	3440	935	561.4	9°	189.4
25.00	3	216	0.101	37.500	25.000	2750	830	779.7	9°	236.8



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for your machining
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