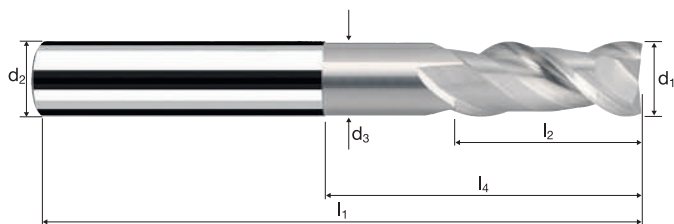
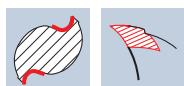
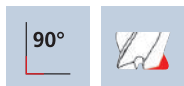


Cylindrical end mills AX

Smooth-edged, medium length version, neck



HM
MG10 λ 40°
 γ 20°

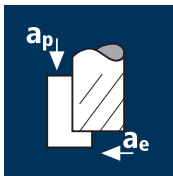


Roughing Finishing

Rm < 850		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast
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Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	α	z	CELERO	
										15650	C15650
Example: Order-N°.	Coating C		Article-N° 15550		ø-Code 180				15550	C15550	
180	3.00	6.00	2.80	63	8.00	20.00	26.63	3.5°	2	●	●
220	4.00	6.00	3.70	63	11.00	22.00	26.95	2.5°	2	●	●
260	5.00	6.00	4.60	63	13.00	24.00	27.27	1.5°	2	●	●
300	6.00	6.00	5.50	63	13.00	25.34	26.00	0.0°	2	●	●
391	8.00	8.00	7.40	72	19.00	34.29	35.00	0.0°	2	●	●
450	10.00	10.00	9.20	84	22.00	42.20	43.00	0.0°	2	●	●
501	12.00	12.00	11.00	97	26.00	50.13	51.00	0.0°	2	●	●
610	16.00	16.00	15.00	108	32.00	58.13	59.00	0.0°	2	●	●
682	20.00	20.00	19.00	122	38.00	70.13	71.00	0.0°	2	●	●

Application



Material

Wrought aluminium
Construction aluminium



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]
3.00	2	396	0.050	4.500	1.200	42015	4200	22.7
4.00	2	528	0.065	6.000	1.600	42015	5460	52.4
5.00	2	550	0.080	7.500	2.000	35015	5600	84.0
6.00	2	550	0.110	9.000	2.400	29180	6420	138.7
8.00	2	550	0.145	12.000	3.200	21885	6345	243.7
10.00	2	550	0.180	15.000	4.000	17505	6305	378.2
12.00	2	550	0.195	18.000	4.800	14590	5690	491.6
16.00	2	550	0.220	24.000	6.400	10940	4815	739.5
20.00	2	550	0.255	30.000	8.000	8755	4465	1071.4

Unalloyed copper



3.00	2	396	0.040	4.500	1.200	42015	3360	18.2
4.00	2	400	0.050	6.000	1.600	31830	3185	30.6
5.00	2	400	0.065	7.500	2.000	25465	3310	49.7
6.00	2	400	0.090	9.000	2.400	21220	3820	82.5
8.00	2	400	0.115	12.000	3.200	15915	3660	140.6
10.00	2	400	0.145	15.000	4.000	12730	3690	221.5
12.00	2	400	0.155	18.000	4.800	10610	3290	284.2
16.00	2	400	0.175	24.000	6.400	7960	2785	427.8
20.00	2	400	0.205	30.000	8.000	6365	2610	626.4

Thermoplastics



3.00	2	396	0.050	4.500	1.200	42015	4200	22.7
4.00	2	528	0.065	6.000	1.600	42015	5460	52.4
5.00	2	660	0.080	7.500	2.000	42015	6725	100.8
6.00	2	792	0.110	9.000	2.400	42015	9245	199.7
8.00	2	1000	0.145	12.000	3.200	39790	11540	443.1
10.00	2	1000	0.180	15.000	4.000	31830	11460	687.5
12.00	2	1000	0.195	18.000	4.800	26525	10345	893.8
16.00	2	1000	0.220	24.000	6.400	19895	8755	1344.5
20.00	2	1000	0.255	30.000	8.000	15915	8115	1948.1

Cast aluminium



3.00	2	396	0.050	4.500	1.200	42015	4200	22.7
4.00	2	440	0.065	6.000	1.600	35015	4550	43.7
5.00	2	440	0.080	7.500	2.000	28010	4480	67.2
6.00	2	440	0.110	9.000	2.400	23345	5135	110.9
8.00	2	440	0.145	12.000	3.200	17505	5075	195.0
10.00	2	440	0.180	15.000	4.000	14005	5040	302.5
12.00	2	440	0.195	18.000	4.800	11670	4550	393.3
16.00	2	440	0.220	24.000	6.400	8755	3850	591.6
20.00	2	440	0.255	30.000	8.000	7005	3570	857.1

Wrought aluminium
Construction aluminium



3.00	2	396	0.035	2.100	3.000	42015	2940	18.5
4.00	2	450	0.045	2.800	4.000	35810	3225	36.1
5.00	2	450	0.055	3.500	5.000	28650	3150	55.1
6.00	2	450	0.075	4.200	6.000	23875	3580	90.2
8.00	2	450	0.100	5.600	8.000	17905	3580	160.4
10.00	2	450	0.125	7.000	10.000	14325	3580	250.7
12.00	2	450	0.135	8.400	12.000	11935	3225	324.9
16.00	2	450	0.155	11.200	16.000	8950	2775	497.3
20.00	2	450	0.180	14.000	20.000	7160	2580	721.9

Unalloyed copper



3.00	2	350	0.030	2.100	3.000	37135	2230	14.0
4.00	2	350	0.035	2.800	4.000	27850	1950	21.8
5.00	2	350	0.045	3.500	5.000	22280	2005	35.1
6.00	2	350	0.060	4.200	6.000	18570	2230	56.1
8.00	2	350	0.080	5.600	8.000	13925	2230	99.8
10.00	2	350	0.100	7.000	10.000	11140	2230	156.0
12.00	2	350	0.110	8.400	12.000	9285	2040	205.9
16.00	2	350	0.125	11.200	16.000	6965	1740	311.9
20.00	2	350	0.145	14.000	20.000	5570	1615	452.3

Thermoplastics



3.00	2	396	0.035	2.100	3.000	42015	2940	18.5
4.00	2	528	0.045	2.800	4.000	42015	3780	42.4
5.00	2	660	0.055	3.500	5.000	42015	4620	80.9
6.00	2	792	0.075	4.200	6.000	42015	6305	158.8
8.00	2	800	0.100	5.600	8.000	31830	6365	285.2
10.00	2	800	0.125	7.000	10.000	25465	6365	445.6
12.00	2	800	0.135	8.400	12.000	21220	5730	577.5
16.00	2	800	0.155	11.200	16.000	15915	4935	884.1
20.00	2	800	0.180	14.000	20.000	12730	4585	1283.4

Cast aluminium



3.00	2	360	0.035	2.100	3.000	38195	2675	16.8
4.00	2	360	0.045	2.800	4.000	28650	2580	28.9
5.00	2	360	0.055	3.500	5.000	22920	2520	44.1
6.00	2	360	0.075	4.200	6.000	19100	2865	72.2
8.00	2	360	0.100	5.600	8.000	14325	2865	128.3
10.00	2	360	0.125	7.000	10.000	11460	2865	200.5
12.00	2	360	0.135	8.400	12.000	9550	2580	259.9
16.00	2	360	0.155	11.200	16.000	7160	2220	397.9
20.00	2	360	0.180	14.000	20.000	5730	2065	577.5