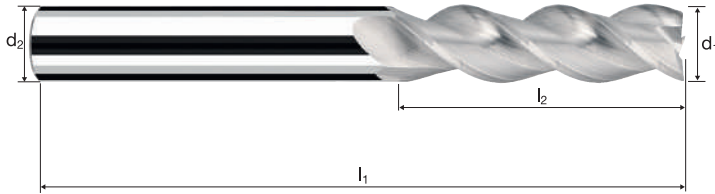
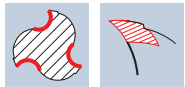
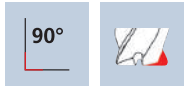


# Cylindrical end mills AX

Smooth-edged, long version



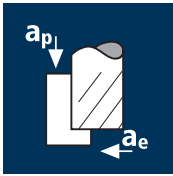
HM  
MG10      λ 40°  
                  γ 20°



Rm < 850	Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast	Cu Copper	Plastic Thermoplast
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Example: Order-N°.							CELERO	
		Coating	Article-N°.	ø-Code			15661	C15661
		C	15561	300			15561	C15561
Ø Code	d <sub>1</sub> e8	d <sub>2</sub> h6	l <sub>1</sub>	l <sub>2</sub>	z			
300	6.00	6.00	70	26.00	3	●	●	●
391	8.00	8.00	80	36.00	3	●	●	●
450	10.00	10.00	100	45.00	3	●	●	●
501	12.00	12.00	110	53.00	3	●	●	●
610	16.00	16.00	123	63.00	3	●	●	●
682	20.00	20.00	141	75.00	3	●	●	●

## Application



## Material

Wrought aluminium  
Construction aluminium



Unalloyed copper



Thermoplastics



Cast aluminium



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>i</sub> [mm]	a <sub>p</sub> [mm]	a <sub>c</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]
6.00	3	350	0.065	18.000	0.900	18570	3620	58.7
8.00	3	350	0.080	24.000	1.200	13925	3340	96.3
10.00	3	350	0.100	30.000	1.500	11140	3340	150.4
12.00	3	350	0.120	36.000	1.800	9285	3340	216.6
16.00	3	350	0.130	48.000	2.400	6965	2715	312.8
20.00	3	350	0.150	60.000	3.000	5570	2505	451.2
6.00	3	220	0.050	18.000	0.900	11670	1750	28.4
8.00	3	220	0.065	24.000	1.200	8755	1705	49.2
10.00	3	220	0.080	30.000	1.500	7005	1680	75.6
12.00	3	220	0.095	36.000	1.800	5835	1665	107.8
16.00	3	220	0.105	48.000	2.400	4375	1380	158.8
20.00	3	220	0.120	60.000	3.000	3500	1260	226.9
6.00	3	600	0.065	18.000	0.900	31830	6205	100.6
8.00	3	600	0.080	24.000	1.200	23875	5730	165.0
10.00	3	600	0.100	30.000	1.500	19100	5730	257.8
12.00	3	600	0.120	36.000	1.800	15915	5730	371.3
16.00	3	600	0.130	48.000	2.400	11935	4655	536.3
20.00	3	600	0.150	60.000	3.000	9550	4295	773.5
6.00	3	280	0.065	18.000	0.900	14855	2895	46.9
8.00	3	280	0.080	24.000	1.200	11140	2675	77.0
10.00	3	280	0.100	30.000	1.500	8915	2675	120.3
12.00	3	280	0.120	36.000	1.800	7425	2675	173.3
16.00	3	280	0.130	48.000	2.400	5570	2170	250.3
20.00	3	280	0.150	60.000	3.000	4455	2005	361.0