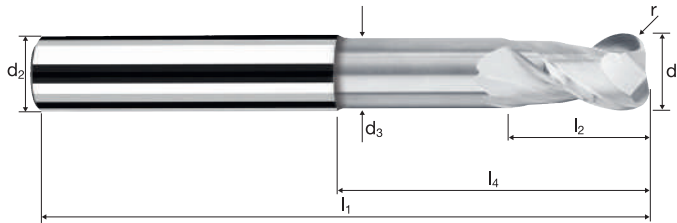
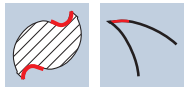
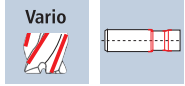


# Corner radius end mills AX

Smooth-edged, version 4xd, neck



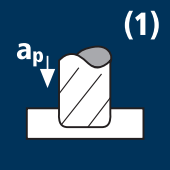

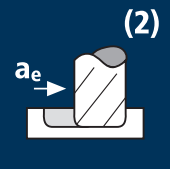

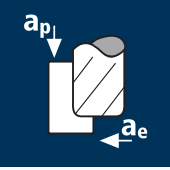

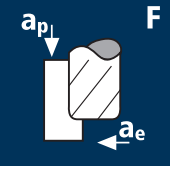



HM  
MG10    λ 40°  
                  γ 20°



ToolSchool 15575 / C15575

		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Ø Code	d <sub>1</sub> e8	d <sub>2</sub> h6	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r 0/+0.03	z	CELERO	
										15574	C15574
Example: Order-N°:    Coating: <b>C</b> Article-N°: <b>15574</b> ø-Code: <b>302</b>											
302	6.00	6.00	5.50	60	7.00	22.15	24.00	1.000	2	●	●
391	8.00	8.00	7.40	68	9.00	29.63	32.00	1.000	2	●	●
450	10.00	10.00	9.20	84	11.00	36.99	40.00	1.000	2	●	●
501	12.00	12.00	11.00	97	13.00	44.29	48.00	1.000	2	●	●
608	16.00	16.00	15.00	115	18.00	59.73	64.00	1.000	2	●	●
680	20.00	20.00	19.00	130	22.00	75.23	80.00	1.000	2	●	●
770	25.00	25.00	24.00	157	27.00	94.68	100.00	1.000	2	●	●
453	10.00	10.00	9.20	84	11.00	36.99	40.00	1.500	2	●	-
503	12.00	12.00	11.00	97	13.00	44.29	48.00	1.500	2	●	-
611	16.00	16.00	15.00	115	18.00	59.73	64.00	2.000	2	●	-
683	20.00	20.00	19.00	130	22.00	75.23	80.00	2.000	2	●	-
307	6.00	6.00	5.50	60	7.00	22.15	24.00	2.500	2	●	●
397	8.00	8.00	7.40	68	9.00	29.63	32.00	2.500	2	●	●
457	10.00	10.00	9.20	84	11.00	36.99	40.00	2.500	2	●	●
506	12.00	12.00	11.00	97	13.00	44.29	48.00	2.500	2	●	●
612	16.00	16.00	15.00	115	18.00	59.73	64.00	2.500	2	●	●
684	20.00	20.00	19.00	130	22.00	75.23	80.00	2.500	2	●	●
774	25.00	25.00	24.00	157	27.00	94.68	100.00	2.500	2	●	●

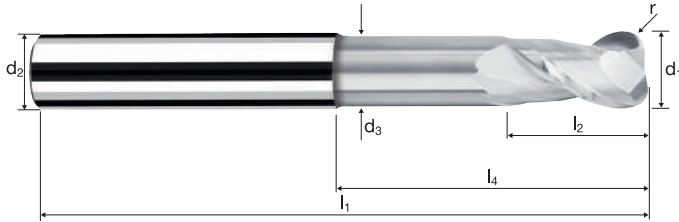
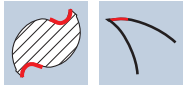
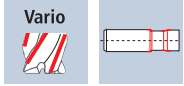
Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
	Wrought aluminium Construction aluminium 	6.00	2	0.090	3.500	6.000	1800	2700	3600	5400
		8.00	2	0.120	4.500	8.000	2400	3600	4800	7200
		10.00	2	0.150	5.000	10.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	12.000	3600	5400	7200	10800
		16.00	2	0.190	6.000	16.000	3800	5700	7600	11400
		20.00	2	0.205	6.500	20.000	4100	6150	8200	12300
		25.00	2	0.215	6.500	25.000	4300	6450	8600	12900
	Wrought aluminium Construction aluminium 	6.00	2	0.090	3.500	3.600	1800	2700	3600	5400
		8.00	2	0.120	4.500	4.800	2400	3600	4800	7200
		10.00	2	0.150	5.000	6.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	7.200	3600	5400	7200	10800
		16.00	2	0.190	6.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	6.500	12.000	4100	6150	8200	12300
		25.00	2	0.215	6.500	15.000	4300	6450	8600	12900
	Wrought aluminium Construction aluminium 	6.00	2	0.090	5.300	3.600	1800	2700	3600	5400
		8.00	2	0.120	6.800	4.800	2400	3600	4800	7200
		10.00	2	0.150	7.500	6.000	3000	4500	6000	9000
		12.00	2	0.180	8.300	7.200	3600	5400	7200	10800
		16.00	2	0.190	9.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	9.800	12.000	4100	6150	8200	12300
		25.00	2	0.215	9.800	15.000	4300	6450	8600	12900
	Wrought aluminium Construction aluminium 	6.00	2	0.025	5.300	0.200	500	750	1000	1500
		8.00	2	0.035	6.800	0.250	700	1050	1400	2100
		10.00	2	0.045	7.500	0.300	900	1350	1800	2700
		12.00	2	0.055	8.300	0.350	1100	1650	2200	3300
		16.00	2	0.055	9.000	0.500	1100	1650	2200	3300
		20.00	2	0.060	9.800	0.600	1200	1800	2400	3600
		25.00	2	0.065	9.800	0.750	1300	1950	2600	3900
	Wrought aluminium Construction aluminium 	6.00	2	0.200	0.400	0.400	4000	6000	8000	12000
		8.00	2	0.265	0.450	0.450	5300	7950	10600	15900
		10.00	2	0.330	0.500	0.500	6600	9900	13200	19800
		12.00	2	0.395	0.600	0.600	7900	11850	15800	23700
		16.00	2	0.420	0.750	0.750	8400	12600	16800	25200
		20.00	2	0.450	1.000	1.000	9000	13500	18000	27000
		25.00	2	0.475	1.200	1.200	9500	14250	19000	28500

# Corner radius end mills AX

Smooth-edged, version 4xd, neck



HM  
MG10      $\lambda$  40°  
                   $\gamma$  20°



Roughing



Finishing

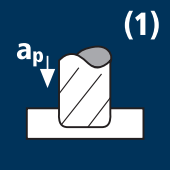

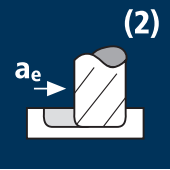

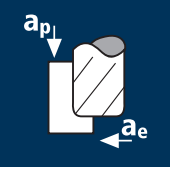

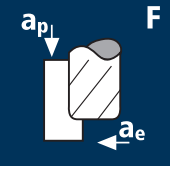





ToolSchool

15575 / C15575

			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Ø Code	d <sub>1</sub> e8	d <sub>2</sub> h6	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r 0/+0.03	z	CELERO	
										15574	C15574
Example: Order-N°.			Coating <b>C</b>	Article-N° <b>15574</b>	ø-Code <b>459</b>						
<b>459</b>	10.00	10.00	9.20	84	11.00	36.99	40.00	4.000	2	●	●
<b>508</b>	12.00	12.00	11.00	97	13.00	44.29	48.00	4.000	2	●	●
<b>614</b>	16.00	16.00	15.00	115	18.00	59.73	64.00	4.000	2	●	●
<b>686</b>	20.00	20.00	19.00	130	22.00	75.23	80.00	4.000	2	●	●
<b>776</b>	25.00	25.00	24.00	157	27.00	94.68	100.00	4.000	2	●	●

Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
 <p>(1)</p>	Wrought aluminium Construction aluminium 	10.00	2	0.150	5.000	10.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	12.000	3600	5400	7200	10800
		16.00	2	0.190	6.000	16.000	3800	5700	7600	11400
		20.00	2	0.205	6.500	20.000	4100	6150	8200	12300
		25.00	2	0.215	6.500	25.000	4300	6450	8600	12900
 <p>(2)</p>	Wrought aluminium Construction aluminium 	10.00	2	0.150	5.000	6.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	7.200	3600	5400	7200	10800
		16.00	2	0.190	6.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	6.500	12.000	4100	6150	8200	12300
		25.00	2	0.215	6.500	15.000	4300	6450	8600	12900
	Wrought aluminium Construction aluminium 	10.00	2	0.150	7.500	6.000	3000	4500	6000	9000
		12.00	2	0.180	8.300	7.200	3600	5400	7200	10800
		16.00	2	0.190	9.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	9.800	12.000	4100	6150	8200	12300
		25.00	2	0.215	9.800	15.000	4300	6450	8600	12900
 <p>F</p>	Wrought aluminium Construction aluminium 	10.00	2	0.045	7.500	0.300	900	1350	1800	2700
		12.00	2	0.055	8.300	0.350	1100	1650	2200	3300
		16.00	2	0.055	9.000	0.500	1100	1650	2200	3300
		20.00	2	0.060	9.800	0.600	1200	1800	2400	3600
		25.00	2	0.065	9.800	0.750	1300	1950	2600	3900
	Wrought aluminium Construction aluminium 	10.00	2	0.330	0.500	0.500	6600	9900	13200	19800
		12.00	2	0.395	0.600	0.600	7900	11850	15800	23700
		16.00	2	0.420	0.750	0.750	8400	12600	16800	25200
		20.00	2	0.450	1.000	1.000	9000	13500	18000	27000
		25.00	2	0.475	1.200	1.200	9500	14250	19000	28500