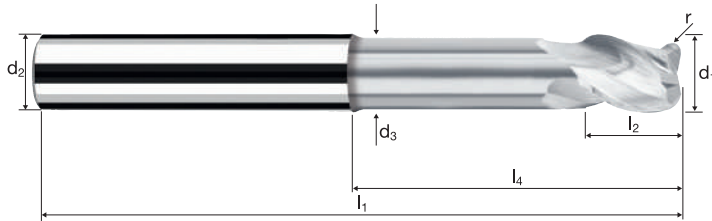
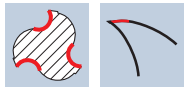
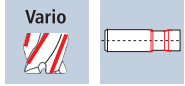


Corner radius end mills AX

Smooth-edged, version 4xd, neck



HM
MG10 λ 40°
 γ 20°



Roughing

Finishing



ToolSchool

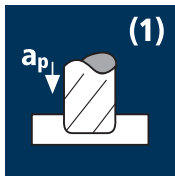
15585 / C15585

		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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										CELERO			
Example: Order-N°.										15584	C15584		
										15584		C15584	
Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	z				
302	6.00	6.00	5.50	60	7.00	22.15	24.00	1.000	3	●	●		
391	8.00	8.00	7.40	68	9.00	29.63	32.00	1.000	3	●	●		
450	10.00	10.00	9.20	84	11.00	36.99	40.00	1.000	3	●	●		
501	12.00	12.00	11.00	97	13.00	44.29	48.00	1.000	3	●	●		
608	16.00	16.00	15.00	115	18.00	59.73	64.00	1.000	3	●	●		
680	20.00	20.00	19.00	130	22.00	75.23	80.00	1.000	3	●	●		
770	25.00	25.00	24.00	157	27.00	94.68	100.00	1.000	3	●	●		
307	6.00	6.00	5.50	60	7.00	22.15	24.00	2.500	3	●	●		
397	8.00	8.00	7.40	68	9.00	29.63	32.00	2.500	3	●	●		
457	10.00	10.00	9.20	84	11.00	36.99	40.00	2.500	3	●	●		
506	12.00	12.00	11.00	97	13.00	44.29	48.00	2.500	3	●	●		
612	16.00	16.00	15.00	115	18.00	59.73	64.00	2.500	3	●	●		
684	20.00	20.00	19.00	130	22.00	75.23	80.00	2.500	3	●	●		
774	25.00	25.00	24.00	157	27.00	94.68	100.00	2.500	3	●	●		
459	10.00	10.00	9.20	84	11.00	36.99	40.00	4.000	3	●	●		
508	12.00	12.00	11.00	97	13.00	44.29	48.00	4.000	3	●	●		
614	16.00	16.00	15.00	115	18.00	59.73	64.00	4.000	3	●	●		
686	20.00	20.00	19.00	130	22.00	75.23	80.00	4.000	3	●	●		
776	25.00	25.00	24.00	157	27.00	94.68	100.00	4.000	3	●	●		

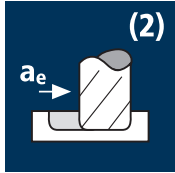
Application

Material



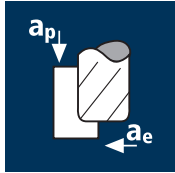
Wrought aluminium
Construction aluminium

d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	3	0.060	3.500	6.000	1800	2700	3600	5400
8.00	3	0.075	4.500	8.000	2250	3375	4500	6750
10.00	3	0.095	5.000	10.000	2850	4275	5700	8550
12.00	3	0.115	5.500	12.000	3450	5175	6900	10350
16.00	3	0.125	6.000	16.000	3750	5625	7500	11250
20.00	3	0.130	6.500	20.000	3900	5850	7800	11700
25.00	3	0.140	6.500	25.000	4200	6300	8400	12600



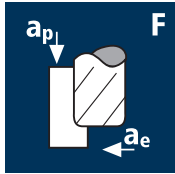
Wrought aluminium
Construction aluminium

d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	3	0.060	3.500	3.600	1800	2700	3600	5400
8.00	3	0.075	4.500	4.800	2250	3375	4500	6750
10.00	3	0.095	5.000	6.000	2850	4275	5700	8550
12.00	3	0.115	5.500	7.200	3450	5175	6900	10350
16.00	3	0.125	6.000	9.600	3750	5625	7500	11250
20.00	3	0.130	6.500	12.000	3900	5850	7800	11700
25.00	3	0.140	6.500	15.000	4200	6300	8400	12600



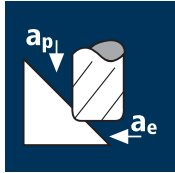
Wrought aluminium
Construction aluminium

d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	3	0.060	5.300	3.600	1800	2700	3600	5400
8.00	3	0.075	6.800	4.800	2250	3375	4500	6750
10.00	3	0.095	7.500	6.000	2850	4275	5700	8550
12.00	3	0.115	8.300	7.200	3450	5175	6900	10350
16.00	3	0.125	9.000	9.600	3750	5625	7500	11250
20.00	3	0.130	9.800	12.000	3900	5850	7800	11700
25.00	3	0.140	9.800	15.000	4200	6300	8400	12600



Wrought aluminium
Construction aluminium

d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	3	0.020	5.300	0.200	600	900	1200	1800
8.00	3	0.025	6.800	0.250	750	1125	1500	2250
10.00	3	0.030	7.500	0.300	900	1350	1800	2700
12.00	3	0.035	8.300	0.350	1050	1575	2100	3150
16.00	3	0.040	9.000	0.500	1200	1800	2400	3600
20.00	3	0.040	9.800	0.600	1200	1800	2400	3600
25.00	3	0.040	9.800	0.750	1200	1800	2400	3600



Wrought aluminium
Construction aluminium

d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	3	0.130	0.350	0.350	3900	5850	7800	11700
8.00	3	0.165	0.400	0.400	4950	7425	9900	14850
10.00	3	0.210	0.450	0.450	6300	9450	12600	18900
12.00	3	0.255	0.500	0.500	7650	11475	15300	22950
16.00	3	0.275	0.600	0.600	8250	12375	16500	24750
20.00	3	0.285	0.750	0.750	8550	12825	17100	25650
25.00	3	0.310	0.800	0.800	9300	13950	18600	27900