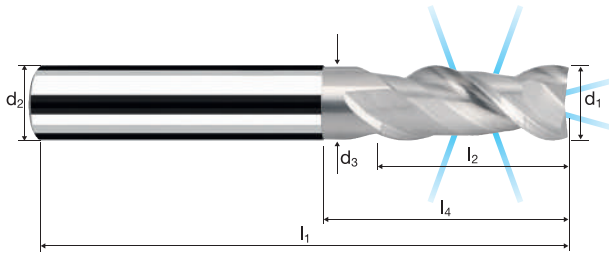
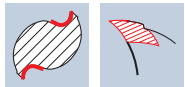
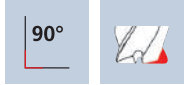


Cylindrical end mills AX

Smooth-edged, normal version, short neck
Integral cooling channel



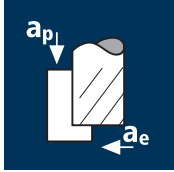
HM
MG10 λ 40°
 γ 20°



Rm < 850	Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast	Cu Copper	Plastic Thermoplast
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										CELERO	
Example: Order-N°: C 15525 300										15625	C15625
										15525	C15525
\emptyset Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	z			
300	6.00	6.00	5.50	57	13.00	19.34	20.00	2	●	●	
391	8.00	8.00	7.40	63	19.00	25.29	26.00	2	●	●	
450	10.00	10.00	9.20	72	22.00	30.20	31.00	2	●	●	
501	12.00	12.00	11.00	83	26.00	36.13	37.00	2	●	●	
610	16.00	16.00	15.00	92	32.00	42.13	43.00	2	●	●	
682	20.00	20.00	19.00	104	38.00	52.13	53.00	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]
6.00	2	650	0.065	9.000	3.300	34485	4485	133.1
8.00	2	650	0.090	12.000	4.400	25865	4655	245.8
10.00	2	650	0.110	15.000	5.500	20690	4550	375.5
12.00	2	650	0.120	18.000	6.600	17240	4140	491.6
16.00	2	650	0.135	24.000	8.800	12930	3490	737.4
20.00	2	650	0.155	30.000	11.000	10345	3205	1058.3

Unalloyed copper



6.00	2	500	0.050	9.000	3.300	26525	2655	78.8
8.00	2	500	0.070	12.000	4.400	19895	2785	147.1
10.00	2	500	0.090	15.000	5.500	15915	2865	236.3
12.00	2	500	0.095	18.000	6.600	13265	2520	299.4
16.00	2	500	0.105	24.000	8.800	9945	2090	441.2
20.00	2	500	0.125	30.000	11.000	7960	1990	656.5

Thermoplastics



6.00	2	792	0.065	9.000	3.300	42015	5460	162.2
8.00	2	1056	0.090	12.000	4.400	42015	7565	399.3
10.00	2	1200	0.110	15.000	5.500	38195	8405	693.3
12.00	2	1200	0.120	18.000	6.600	31830	7640	907.6
16.00	2	1200	0.135	24.000	8.800	23875	6445	1361.3
20.00	2	1200	0.155	30.000	11.000	19100	5920	1953.8

Cast aluminium



6.00	2	520	0.065	9.000	3.300	27585	3585	106.5
8.00	2	520	0.090	12.000	4.400	20690	3725	196.6
10.00	2	520	0.110	15.000	5.500	16550	3640	300.4
12.00	2	520	0.120	18.000	6.600	13795	3310	393.3
16.00	2	520	0.135	24.000	8.800	10345	2795	589.9
20.00	2	520	0.155	30.000	11.000	8275	2565	846.6



Wrought aluminium
Construction aluminium



6.00	2	550	0.045	5.400	6.000	29180	2625	85.1
8.00	2	550	0.060	7.200	8.000	21885	2625	151.3
10.00	2	550	0.075	9.000	10.000	17505	2625	236.3
12.00	2	550	0.085	10.800	12.000	14590	2480	321.4
16.00	2	550	0.095	14.400	16.000	10940	2080	479.0
20.00	2	550	0.110	18.000	20.000	8755	1925	693.3

Unalloyed copper



6.00	2	450	0.040	5.400	6.000	23875	1910	61.9
8.00	2	450	0.050	7.200	8.000	17905	1790	103.1
10.00	2	450	0.060	9.000	10.000	14325	1720	154.7
12.00	2	450	0.070	10.800	12.000	11935	1670	216.6
16.00	2	450	0.075	14.400	16.000	8950	1345	309.4
20.00	2	450	0.090	18.000	20.000	7160	1290	464.1

Thermoplastics



6.00	2	792	0.045	5.400	6.000	42015	3780	122.5
8.00	2	1000	0.060	7.200	8.000	39790	4775	275.0
10.00	2	1000	0.075	9.000	10.000	31830	4775	429.7
12.00	2	1000	0.085	10.800	12.000	26525	4510	584.4
16.00	2	1000	0.095	14.400	16.000	19895	3780	870.9
20.00	2	1000	0.110	18.000	20.000	15915	3500	1260.5

Cast aluminium



6.00	2	440	0.045	5.400	6.000	23345	2100	68.1
8.00	2	440	0.060	7.200	8.000	17505	2100	121.0
10.00	2	440	0.075	9.000	10.000	14005	2100	189.1
12.00	2	440	0.085	10.800	12.000	11670	1985	257.1
16.00	2	440	0.095	14.400	16.000	8755	1665	383.2
20.00	2	440	0.110	18.000	20.000	7005	1540	554.6