

Corner radius end mills E-Cut Alu

Smooth-edged, normal version, short neck

Base-X
B

$$l_2 = 2.2 \times d_1$$

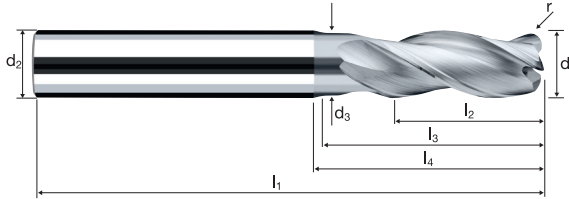
$$l_3 = 3.0 \times d_1$$

new!

HM MG10 λ **34°**
 γ **24°**

G2.5

Vario



Roughing

Finishing

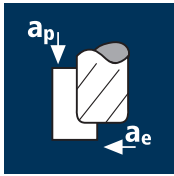


ReTool®

Al Aluminium > 99% Al Aluminium Alloy Al Aluminium Cast Cu Copper Plastic Thermoplast

Ø Code	d ₁ e8	d ₂ h5	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	α	z	Example: Order-N°.	
											Coating	Article-N°.
											8567	178
178	3.00	6.00	2.80	54	6.60	9.00	12.33	0.200	7.2°	3	●	
218	4.00	6.00	3.70	54	9.00	12.00	14.54	0.200	4.2°	3	●	
258	5.00	6.00	4.60	57	11.00	15.00	16.72	0.200	2.0°	3	●	
180	3.00	6.00	2.80	54	6.60	9.00	12.33	0.500	7.2°	3	●	
220	4.00	6.00	3.70	54	9.00	12.00	14.54	0.500	4.2°	3	●	
260	5.00	6.00	4.60	57	11.00	15.00	16.72	0.500	2.0°	3	●	
300	6.00	6.00	5.50	57	13.50	18.00	19.85	0.500	0.0°	3	●	
388	8.00	8.00	7.40	63	18.00	24.00	26.37	0.500	0.0°	3	●	
448	10.00	10.00	9.20	74	22.00	30.00	33.01	0.500	0.0°	3	●	
302	6.00	6.00	5.50	57	13.50	18.00	19.85	1.000	0.0°	3	●	
391	8.00	8.00	7.40	63	18.00	24.00	26.37	1.000	0.0°	3	●	
450	10.00	10.00	9.20	74	22.00	30.00	33.01	1.000	0.0°	3	●	
501	12.00	12.00	11.00	85	27.00	36.00	39.71	1.000	0.0°	3	●	
608	16.00	16.00	15.00	102	36.00	48.00	52.27	1.000	0.0°	3	●	
455	10.00	10.00	9.20	74	22.00	30.00	33.01	2.000	0.0°	3	●	
505	12.00	12.00	11.00	85	27.00	36.00	39.71	2.000	0.0°	3	●	
611	16.00	16.00	15.00	102	36.00	48.00	52.27	2.000	0.0°	3	●	
683	20.00	20.00	19.00	115	44.00	60.00	64.77	2.000	0.0°	3	●	

Application



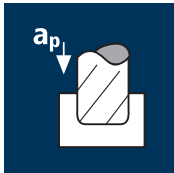
Material

Wrought aluminium
Construction aluminium

Unalloyed copper

Thermoplastics

Cast aluminium



Wrought aluminium
Construction aluminium

Unalloyed copper

Thermoplastics

Cast aluminium

d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min ⁻¹]	v_f [mm/min]	Q [cm ³ /min]
3.00	3	396	0.056	4.500	1.350	42000	6993	42.5
4.00	3	500	0.074	6.000	1.800	39790	8833	95.4
5.00	3	500	0.093	7.500	2.250	31830	8833	149.1
6.00	3	500	0.111	9.000	2.700	26525	8833	214.6
8.00	3	500	0.148	12.000	3.600	19895	8833	381.6
10.00	3	500	0.185	15.000	4.500	15915	8833	596.2
12.00	3	500	0.222	18.000	5.400	13265	8835	858.7
16.00	3	500	0.237	24.000	7.200	9945	7065	1220.8
20.00	3	500	0.278	30.000	9.000	7960	6627	1789.2
3.00	3	375	0.041	4.500	1.350	39790	4942	30.0
4.00	3	375	0.055	6.000	1.800	29840	4942	53.4
5.00	3	375	0.069	7.500	2.250	23875	4942	83.4
6.00	3	375	0.083	9.000	2.700	19895	4942	120.1
8.00	3	375	0.110	12.000	3.600	14920	4942	213.5
10.00	3	375	0.138	15.000	4.500	11935	4941	333.5
12.00	3	375	0.166	18.000	5.400	9945	4941	480.2
16.00	3	375	0.177	24.000	7.200	7460	3953	683.1
20.00	3	375	0.207	30.000	9.000	5970	3707	1001.0
3.00	3	396	0.067	4.500	1.350	42000	8392	51.0
4.00	3	500	0.089	6.000	1.800	39790	10600	114.5
5.00	3	500	0.111	7.500	2.250	31830	10599	178.9
6.00	3	500	0.133	9.000	2.700	26525	10599	257.6
8.00	3	500	0.178	12.000	3.600	19895	10600	457.9
10.00	3	500	0.222	15.000	4.500	15915	10599	715.5
12.00	3	500	0.266	18.000	5.400	13265	10601	1030.5
16.00	3	500	0.284	24.000	7.200	9945	8478	1465.0
20.00	3	500	0.333	30.000	9.000	7960	7952	2147.0
3.00	3	396	0.044	4.500	1.350	42000	5594	34.0
4.00	3	400	0.059	6.000	1.800	31830	5653	61.1
5.00	3	400	0.074	7.500	2.250	25465	5653	95.4
6.00	3	400	0.089	9.000	2.700	21220	5653	137.4
8.00	3	400	0.118	12.000	3.600	15915	5653	244.2
10.00	3	400	0.148	15.000	4.500	12730	5652	381.5
12.00	3	400	0.178	18.000	5.400	10610	5653	549.5
16.00	3	400	0.189	24.000	7.200	7960	4524	781.7
20.00	3	400	0.222	30.000	9.000	6365	4239	1144.6
3.00	3	395	0.032	4.500	3.000	41910	4012	54.2
4.00	3	400	0.043	6.000	4.000	31830	4063	97.5
5.00	3	400	0.053	7.500	5.000	25465	4063	152.4
6.00	3	400	0.064	9.000	6.000	21220	4063	219.4
8.00	3	400	0.085	12.000	8.000	15915	4063	390.1
10.00	3	400	0.106	15.000	10.000	12730	4063	609.4
12.00	3	400	0.128	18.000	12.000	10610	4063	877.6
16.00	3	400	0.136	24.000	16.000	7960	3252	1248.6
20.00	3	400	0.160	30.000	20.000	6365	3047	1828.1
3.00	3	300	0.024	4.500	3.000	31830	2273	30.7
4.00	3	300	0.032	6.000	4.000	23875	2273	54.6
5.00	3	300	0.040	7.500	5.000	19100	2273	85.3
6.00	3	300	0.048	9.000	6.000	15915	2273	122.7
8.00	3	300	0.063	12.000	8.000	11935	2273	218.2
10.00	3	300	0.079	15.000	10.000	9550	2273	341.0
12.00	3	300	0.095	18.000	12.000	7960	2274	491.2
16.00	3	300	0.102	24.000	16.000	5970	1819	698.5
20.00	3	300	0.119	30.000	20.000	4775	1705	1023.0
3.00	3	400	0.038	4.500	3.000	42440	4876	65.8
4.00	3	400	0.051	6.000	4.000	31830	4876	117.0
5.00	3	400	0.064	7.500	5.000	25465	4876	182.8
6.00	3	400	0.077	9.000	6.000	21220	4876	263.3
8.00	3	400	0.102	12.000	8.000	15915	4876	468.1
10.00	3	400	0.128	15.000	10.000	12730	4875	731.3
12.00	3	400	0.153	18.000	12.000	10610	4876	1053.2
16.00	3	400	0.163	24.000	16.000	7960	3902	1498.3
20.00	3	400	0.191	30.000	20.000	6365	3656	2193.7
3.00	3	320	0.026	4.500	3.000	33955	2601	35.1
4.00	3	320	0.034	6.000	4.000	25465	2601	62.4
5.00	3	320	0.043	7.500	5.000	20370	2600	97.5
6.00	3	320	0.051	9.000	6.000	16975	2600	140.4
8.00	3	320	0.068	12.000	8.000	12730	2600	249.6
10.00	3	320	0.085	15.000	10.000	10185	2600	390.0
12.00	3	320	0.102	18.000	12.000	8490	2601	561.8
16.00	3	320	0.109	24.000	16.000	6365	2080	798.7
20.00	3	320	0.128	30.000	20.000	5095	1951	1170.7

