

Corner radius end mills E-Cut Alu

Smooth-edged, medium length version, neck

Base-X
B

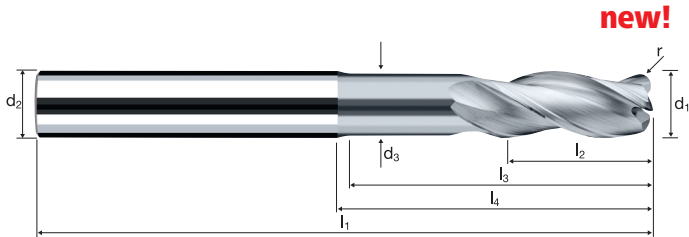
$$l_2 = 2.2 \times d_1$$

$$l_3 = 4.5 \times d_1$$

HM MG10 λ **34°**
 γ **24°**

G2.5

Vario



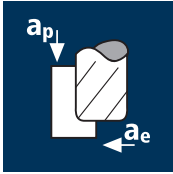
Roughing **Finishing**

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°.
											8577	178
178	3.00	6.00	2.80	57	6.60	13.50	16.83	0.200	5.3°	3	●	
218	4.00	6.00	3.70	60	9.00	18.00	20.54	0.200	3.0°	3	●	
258	5.00	6.00	4.60	63	11.00	22.50	24.22	0.200	1.4°	3	●	
180	3.00	6.00	2.80	57	6.60	13.50	16.83	0.500	5.3°	3	●	
220	4.00	6.00	3.70	60	9.00	18.00	20.54	0.500	3.0°	3	●	
260	5.00	6.00	4.60	63	11.00	22.50	24.22	0.500	1.4°	3	●	
300	6.00	6.00	5.50	65	13.50	27.00	28.85	0.500	0.0°	3	●	
388	8.00	8.00	7.40	76	18.00	36.00	38.37	0.500	0.0°	3	●	
448	10.00	10.00	9.20	90	22.00	45.00	48.01	0.500	0.0°	3	●	
302	6.00	6.00	5.50	65	13.50	27.00	28.85	1.000	0.0°	3	●	
391	8.00	8.00	7.40	76	18.00	36.00	38.37	1.000	0.0°	3	●	
450	10.00	10.00	9.20	90	22.00	45.00	48.01	1.000	0.0°	3	●	
501	12.00	12.00	11.00	105	27.00	54.00	57.71	1.000	0.0°	3	●	
608	16.00	16.00	15.00	125	36.00	72.00	76.27	1.000	0.0°	3	●	
455	10.00	10.00	9.20	90	22.00	45.00	48.01	2.000	0.0°	3	●	
505	12.00	12.00	11.00	105	27.00	54.00	57.71	2.000	0.0°	3	●	
611	16.00	16.00	15.00	125	36.00	72.00	76.27	2.000	0.0°	3	●	
683	20.00	20.00	19.00	145	44.00	90.00	94.77	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	0.042	4.500	1.350	42000	5292	32.1
4.00	3	475	0.056	6.000	1.800	37800	6350	68.6
5.00	3	475	0.070	7.500	2.250	30240	6350	107.2
6.00	3	475	0.084	9.000	2.700	25200	6350	154.3
8.00	3	475	0.112	12.000	3.600	18900	6350	274.3
10.00	3	475	0.140	15.000	4.500	15120	6350	428.7
12.00	3	475	0.168	18.000	5.400	12600	6350	617.3
16.00	3	475	0.179	24.000	7.200	9450	5080	877.9
20.00	3	475	0.210	30.000	9.000	7560	4763	1286.0
3.00	3	355	0.032	4.500	1.350	37665	3559	21.6
4.00	3	355	0.042	6.000	1.800	28250	3560	38.4
5.00	3	355	0.053	7.500	2.250	22600	3560	60.1
6.00	3	355	0.063	9.000	2.700	18835	3560	86.5
8.00	3	355	0.084	12.000	3.600	14125	3560	153.8
10.00	3	355	0.105	15.000	4.500	11300	3560	240.3
12.00	3	355	0.126	18.000	5.400	9415	3559	345.9
16.00	3	355	0.134	24.000	7.200	7065	2849	492.2
20.00	3	355	0.158	30.000	9.000	5650	2670	720.8
3.00	3	396	0.050	4.500	1.350	42000	6350	38.6
4.00	3	475	0.067	6.000	1.800	37800	7621	82.3
5.00	3	475	0.084	7.500	2.250	30240	7621	128.6
6.00	3	475	0.101	9.000	2.700	25200	7621	185.2
8.00	3	475	0.134	12.000	3.600	18900	7621	329.2
10.00	3	475	0.168	15.000	4.500	15120	7621	514.4
12.00	3	475	0.202	18.000	5.400	12600	7621	740.7
16.00	3	475	0.215	24.000	7.200	9450	6096	1053.5
20.00	3	475	0.252	30.000	9.000	7560	5715	1543.2
3.00	3	380	0.042	4.500	1.350	40320	5080	30.9
4.00	3	380	0.056	6.000	1.800	30240	5080	54.9
5.00	3	380	0.070	7.500	2.250	24190	5080	85.7
6.00	3	380	0.084	9.000	2.700	20160	5080	123.5
8.00	3	380	0.112	12.000	3.600	15120	5080	219.5
10.00	3	380	0.140	15.000	4.500	12095	5080	342.9
12.00	3	380	0.168	18.000	5.400	10080	5080	493.8
16.00	3	380	0.179	24.000	7.200	7560	4064	702.3
20.00	3	380	0.210	30.000	9.000	6050	3812	1029.1
3.00	3	380	0.024	4.500	3.000	40320	2921	39.4
4.00	3	380	0.032	6.000	4.000	30240	2921	70.1
5.00	3	380	0.040	7.500	5.000	24190	2921	109.5
6.00	3	380	0.048	9.000	6.000	20160	2921	157.7
8.00	3	380	0.064	12.000	8.000	15120	2921	280.4
10.00	3	380	0.081	15.000	10.000	12095	2921	438.1
12.00	3	380	0.097	18.000	12.000	10080	2921	631.0
16.00	3	380	0.103	24.000	16.000	7560	2337	897.4
20.00	3	380	0.121	30.000	20.000	6050	2192	1315.0
3.00	3	284	0.018	4.500	3.000	30135	1638	22.1
4.00	3	284	0.024	6.000	4.000	22600	1637	39.3
5.00	3	284	0.030	7.500	5.000	18080	1637	61.4
6.00	3	284	0.036	9.000	6.000	15065	1637	88.4
8.00	3	284	0.048	12.000	8.000	11300	1637	157.2
10.00	3	284	0.060	15.000	10.000	9040	1637	245.6
12.00	3	284	0.072	18.000	12.000	7535	1638	353.7
16.00	3	284	0.077	24.000	16.000	5650	1310	503.0
20.00	3	284	0.091	30.000	20.000	4520	1228	736.8
3.00	3	380	0.029	4.500	3.000	40320	3505	47.3
4.00	3	380	0.039	6.000	4.000	30240	3505	84.1
5.00	3	380	0.048	7.500	5.000	24190	3505	131.4
6.00	3	380	0.058	9.000	6.000	20160	3505	189.3
8.00	3	380	0.077	12.000	8.000	15120	3505	336.5
10.00	3	380	0.097	15.000	10.000	12095	3505	525.8
12.00	3	380	0.116	18.000	12.000	10080	3505	757.2
16.00	3	380	0.124	24.000	16.000	7560	2804	1076.9
20.00	3	380	0.145	30.000	20.000	6050	2630	1577.9
3.00	3	304	0.024	4.500	3.000	32255	2337	31.5
4.00	3	304	0.032	6.000	4.000	24190	2337	56.1
5.00	3	304	0.040	7.500	5.000	19355	2337	87.6
6.00	3	304	0.048	9.000	6.000	16130	2337	126.2
8.00	3	304	0.064	12.000	8.000	12095	2337	224.3
10.00	3	304	0.081	15.000	10.000	9675	2337	350.5
12.00	3	304	0.097	18.000	12.000	8065	2337	504.8
16.00	3	304	0.103	24.000	16.000	6050	1870	718.2
20.00	3	304	0.121	30.000	20.000	4840	1753	1052.0

