Cylindrical 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!

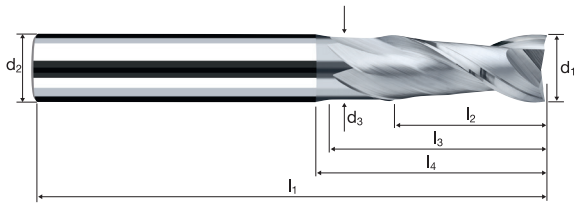
HM MG10

λ 34°
γ 24°

90°

G 2.5

Vario



Roughing

Finishing

ReTool®

III

Al Aluminium > 99%

Al Aluminium Alloy

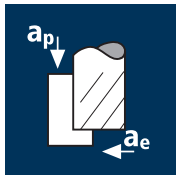
Al Aluminium Cast

Cu Copper

Plastic Thermoplast

Example: **Order-N°.** Coating **8561** Article-N°. ø-Code **100**

Ø Code	d_1 e8	d_2 h5	d_3	l_1	l_2	l_3	l_4	α	z	**8661**	**8561**
100	1.00	6.00	0.95	50	2.20	3.00	8.41	16.8°	2	●	
140	2.00	6.00	1.90	51	4.40	6.00	10.18	11.4°	2	●	
180	3.00	6.00	2.80	54	6.60	9.00	12.33	7.2°	2	●	
220	4.00	6.00	3.70	54	9.00	12.00	14.54	4.2°	2	●	
260	5.00	6.00	4.60	57	11.00	15.00	16.72	2.0°	2	●	
300	6.00	6.00	5.50	57	13.50	18.00	19.85	0.0°	2	●	
391	8.00	8.00	7.40	63	18.00	24.00	26.37	0.0°	2	●	
450	10.00	10.00	9.20	74	22.00	30.00	33.01	0.0°	2	●	

Application	Material	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 [cm³/min]
	Wrought aluminium Construction aluminium	1.00	2	132	0.020	1.500	0.650	42000	1680	1.6
		2.00	2	264	0.040	3.000	1.300	42000	3360	13.1
		3.00	2	396	0.060	4.500	1.950	42000	5040	44.2
		4.00	2	500	0.080	6.000	2.600	39790	6366	99.3
		5.00	2	500	0.100	7.500	3.250	31830	6366	155.2
		6.00	2	500	0.120	9.000	3.900	26525	6366	223.4
		8.00	2	500	0.160	12.000	5.200	19895	6366	397.3
		10.00	2	500	0.200	15.000	6.500	15915	6366	620.7
	Unalloyed copper	1.00	2	132	0.014	1.500	0.650	42000	1176	1.1
		2.00	2	264	0.028	3.000	1.300	42000	2352	9.2
		3.00	2	350	0.042	4.500	1.950	37135	3119	27.4
		4.00	2	350	0.056	6.000	2.600	27850	3119	48.7
		5.00	2	350	0.070	7.500	3.250	22280	3119	76.0
		6.00	2	350	0.084	9.000	3.900	18570	3120	109.5
		8.00	2	350	0.112	12.000	5.200	13925	3119	194.6
		10.00	2	350	0.140	15.000	6.500	11140	3119	304.1
	Thermoplastics	1.00	2	132	0.024	1.500	0.650	42000	2016	2.0
		2.00	2	264	0.048	3.000	1.300	42000	4032	15.7
		3.00	2	396	0.072	4.500	1.950	42000	6048	53.1
		4.00	2	500	0.096	6.000	2.600	39790	7640	119.2
		5.00	2	500	0.120	7.500	3.250	31830	7639	186.2
		6.00	2	500	0.144	9.000	3.900	26525	7639	268.1
		8.00	2	500	0.192	12.000	5.200	19895	7640	476.7
		10.00	2	500	0.240	15.000	6.500	15915	7639	744.8
	Cast aluminium	1.00	2	132	0.020	1.500	0.650	42000	1680	1.6
		2.00	2	264	0.040	3.000	1.300	42000	3360	13.1
		3.00	2	396	0.060	4.500	1.950	42000	5040	44.2
		4.00	2	400	0.080	6.000	2.600	31830	5093	79.4
		5.00	2	400	0.100	7.500	3.250	25465	5093	124.1
		6.00	2	400	0.120	9.000	3.900	21220	5093	178.8
		8.00	2	400	0.160	12.000	5.200	15915	5093	317.8
		10.00	2	400	0.200	15.000	6.500	12730	5092	496.5
	Wrought aluminium Construction aluminium	1.00	2	132	0.016	1.500	1.000	42000	1344	2.0
		2.00	2	264	0.032	3.000	2.000	42000	2688	16.1
		3.00	2	396	0.048	4.500	3.000	42000	4032	54.4
		4.00	2	425	0.064	6.000	4.000	33820	4329	103.9
		5.00	2	425	0.080	7.500	5.000	27055	4329	162.3
		6.00	2	425	0.096	9.000	6.000	22545	4329	233.7
		8.00	2	425	0.128	12.000	8.000	16910	4329	415.6
		10.00	2	425	0.160	15.000	10.000	13530	4330	649.4
	Unalloyed copper	1.00	2	132	0.011	1.500	1.000	42000	941	1.4
		2.00	2	264	0.022	3.000	2.000	42000	1882	11.3
		3.00	2	300	0.034	4.500	3.000	31830	2139	28.9
		4.00	2	300	0.045	6.000	4.000	23875	2139	51.3
		5.00	2	300	0.056	7.500	5.000	19100	2139	80.2
		6.00	2	300	0.067	9.000	6.000	15915	2139	115.5
		8.00	2	300	0.090	12.000	8.000	11935	2139	205.3
		10.00	2	300	0.112	15.000	10.000	9550	2139	320.9
	Thermoplastics	1.00	2	132	0.019	1.500	1.000	42000	1613	2.4
		2.00	2	264	0.038	3.000	2.000	42000	3226	19.4
		3.00	2	396	0.058	4.500	3.000	42000	4838	65.3
		4.00	2	425	0.077	6.000	4.000	33820	5195	124.7
		5.00	2	425	0.096	7.500	5.000	27055	5195	194.8
		6.00	2	425	0.115	9.000	6.000	22545	5194	280.5
		8.00	2	425	0.154	12.000	8.000	16910	5195	498.7
		10.00	2	425	0.192	15.000	10.000	13530	5196	779.3
	Cast aluminium	1.00	2	132	0.016	1.500	1.000	42000	1344	2.0
		2.00	2	264	0.032	3.000	2.000	42000	2688	16.1
		3.00	2	396	0.048	4.500	3.000	42000	4032	54.4
		4.00	2	340	0.064	6.000	4.000	27055	3463	83.1
		5.00	2	340	0.080	7.500	5.000	21645	3463	129.9
		6.00	2	340	0.096	9.000	6.000	18040	3464	187.0
		8.00	2	340	0.128	12.000	8.000	13530	3464	332.5
		10.00	2	340	0.160	15.000	10.000	10825	3464	519.6