Corner radius end mills E-Cut Alu

Smooth-edged, normal version, short neck

Base-X **B**

$l_2 = 2.2 \times d_1$

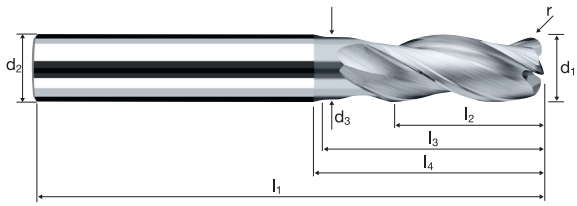
$l_3 = 3.0 \times d_1$

new!

HM MG10 | λ 34° γ 24°

G 2.5

Vario



Roughing

Finishing

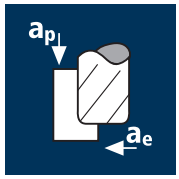
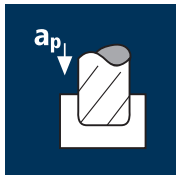
ReTool®

III

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

Example: **Order-N°.** Coating **8567** Article-N°. **178** ø-Code

											8667	8567
Ø Code	d_1 e8	d_2 h5	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z		
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	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]
	Wrought aluminium Construction aluminium	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
	Unalloyed copper	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
	Thermoplastics	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
	Cast aluminium	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
	Wrought aluminium Construction aluminium	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
	Unalloyed copper	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
	Thermoplastics	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
	Cast aluminium	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

Corner radius end mills E-Cut Alu

Smooth-edged, normal version, short neck

Base-X **B**

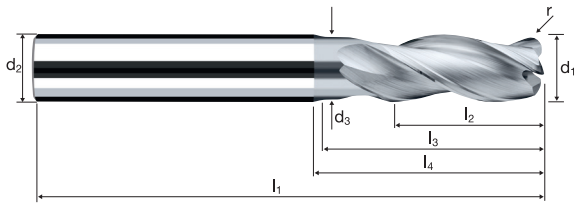
$l_2 = 2.2 \times d_1$

$l_3 = 3.0 \times d_1$

HM MG10 | λ 34° γ 24°

G 2.5

Vario



new!

Roughing

Finishing

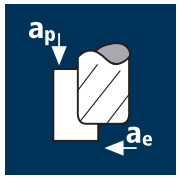
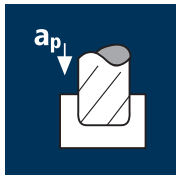
ReTool®

III

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

Example: **Order-N°.** Coating | Article-N°. **8567** | ø-Code **507**

Ø Code	d_1 e8	d_2 h5	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z	**8667**	**8567**
507	12.00	12.00	11.00	85	27.00	36.00	39.71	3.000	0.0°	3	●	
613	16.00	16.00	15.00	102	36.00	48.00	52.27	3.000	0.0°	3	●	
685	20.00	20.00	19.00	115	44.00	60.00	64.77	3.000	0.0°	3	●	

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	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
	Unalloyed copper	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
	Thermoplastics	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
	Cast aluminium	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
	Wrought aluminium Construction aluminium	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
	Unalloyed copper	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
	Thermoplastics	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
	Cast aluminium	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