

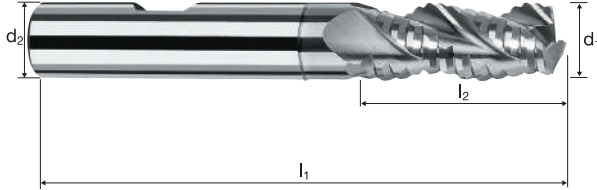
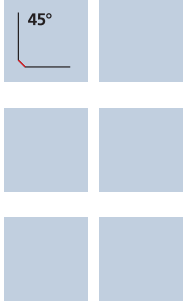
# Cylindrical end mills

Profiled, normal version

HSS

HSS-E  
Co8

$\lambda$  40°  
 $\gamma$  18°

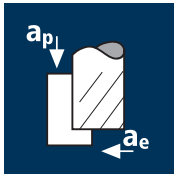


Rm < 850		Al Aluminium > 99%	Al Aluminium Alloy			Cu Copper	Plastic Thermoplast
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III

Example: Order-N°.										CELERO
Coating: C Article-N°: 0391 ø-Code: 300										C0391
Ø Code	d <sub>1</sub> k8	d <sub>2</sub> h6	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	45°	z			
300	6.00	6.00	57	13.00	-	0.40 0.0°	3			●
402	8.00	10.00	69	19.00	28.50	0.40 2.5°	3			●
450	10.00	10.00	72	22.00	-	0.40 0.0°	3			●
501	12.00	12.00	83	26.00	-	0.40 0.0°	3			●
610	16.00	16.00	92	32.00	-	0.50 0.0°	3			●
682	20.00	20.00	104	38.00	-	0.50 0.0°	3			●
772	25.00	25.00	121	45.00	-	0.70 0.0°	3			●

## Application



## Material

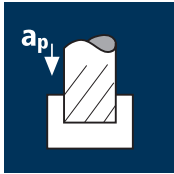
Wrought aluminium  
Construction aluminium



Unalloyed copper



Thermoplastics



Wrought aluminium  
Construction aluminium



Unalloyed copper



Thermoplastics



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>t</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]
6.00	3	207	0.055	9.000	2.400	10980	1810	39.1
8.00	3	207	0.070	12.000	3.200	8235	1730	66.4
10.00	3	207	0.090	15.000	4.000	6590	1780	106.7
12.00	3	207	0.125	18.000	4.800	5490	2060	177.9
16.00	3	207	0.170	24.000	6.400	4120	2100	322.6
20.00	3	207	0.210	30.000	8.000	3295	2075	498.1
25.00	3	207	0.265	37.500	10.000	2635	2095	785.7

6.00	3	88	0.055	9.000	2.400	4670	770	16.6
8.00	3	88	0.070	12.000	3.200	3500	735	28.2
10.00	3	88	0.090	15.000	4.000	2800	755	45.4
12.00	3	88	0.125	18.000	4.800	2335	875	75.6
16.00	3	88	0.170	24.000	6.400	1750	895	137.1
20.00	3	88	0.210	30.000	8.000	1400	880	211.8
25.00	3	88	0.265	37.500	10.000	1120	890	334.0

6.00	3	224	0.055	9.000	2.400	11885	1960	42.4
8.00	3	224	0.070	12.000	3.200	8915	1870	71.9
10.00	3	224	0.090	15.000	4.000	7130	1925	115.5
12.00	3	224	0.125	18.000	4.800	5940	2230	192.5
16.00	3	224	0.170	24.000	6.400	4455	2275	349.1
20.00	3	224	0.210	30.000	8.000	3565	2245	539.0
25.00	3	224	0.265	37.500	10.000	2850	2265	850.3

6.00	3	189	0.045	6.000	6.000	10025	1355	48.7
8.00	3	189	0.055	8.000	8.000	7520	1240	79.4
10.00	3	189	0.070	10.000	10.000	6015	1265	126.3
12.00	3	189	0.100	12.000	12.000	5015	1505	216.6
16.00	3	189	0.135	16.000	16.000	3760	1525	389.8
20.00	3	189	0.170	20.000	20.000	3010	1535	613.6
25.00	3	189	0.210	25.000	25.000	2405	1515	947.5

6.00	3	82	0.045	6.000	6.000	4350	585	21.1
8.00	3	82	0.055	8.000	8.000	3265	540	34.5
10.00	3	82	0.070	10.000	10.000	2610	550	54.8
12.00	3	82	0.100	12.000	12.000	2175	655	94.0
16.00	3	82	0.135	16.000	16.000	1630	660	169.1
20.00	3	82	0.170	20.000	20.000	1305	665	266.2
25.00	3	82	0.210	25.000	25.000	1045	660	411.1

6.00	3	224	0.045	6.000	6.000	11885	1605	57.8
8.00	3	224	0.055	8.000	8.000	8915	1470	94.1
10.00	3	224	0.070	10.000	10.000	7130	1495	149.7
12.00	3	224	0.100	12.000	12.000	5940	1785	256.7
16.00	3	224	0.135	16.000	16.000	4455	1805	462.0
20.00	3	224	0.170	20.000	20.000	3565	1820	727.3
25.00	3	224	0.210	25.000	25.000	2850	1795	1123.0