

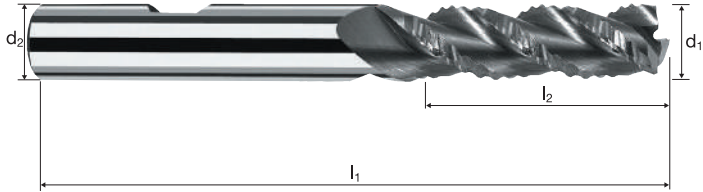
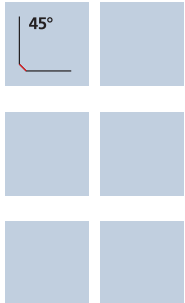
# Cylindrical end mills AX

Profiled, medium length version



HM  
MG10

$\lambda$  40°  
 $\gamma$  18°



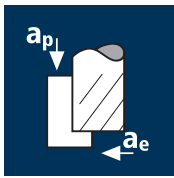
Roughing

Finishing

Rm < 850		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Example: Order-N°.		Coating <b>C</b>	Article-N° <b>15397</b>	ø-Code <b>300</b>	Ø			z	CELERO
Ø	d <sub>1</sub> e8	d <sub>2</sub> h6	l <sub>1</sub>	l <sub>2</sub>	45°				
<b>300</b>	6.00	6.00	63	19.00	0.40	3	●		
<b>391</b>	8.00	8.00	72	28.00	0.40	3	●		
<b>450</b>	10.00	10.00	84	34.00	0.40	3	●		
<b>501</b>	12.00	12.00	97	40.00	0.40	3	●		
<b>610</b>	16.00	16.00	108	48.00	0.50	3	●		
<b>682</b>	20.00	20.00	122	56.00	0.50	3	●		

## Application



## Material

Wrought aluminium  
Construction aluminium



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>s</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	600	0.065	12.000	1.800	31830	6205	134.1
8.00	3	600	0.090	16.000	2.400	23875	6445	247.5
10.00	3	600	0.110	20.000	3.000	19100	6305	378.2
12.00	3	600	0.135	24.000	3.600	15915	6445	556.9
16.00	3	600	0.180	32.000	4.800	11935	6445	990.1
20.00	3	600	0.220	40.000	6.000	9550	6305	1512.6

Unalloyed copper



6.00	3	400	0.065	12.000	1.800	21220	4140	89.4
8.00	3	400	0.090	16.000	2.400	15915	4295	165.0
10.00	3	400	0.110	20.000	3.000	12730	4200	252.1
12.00	3	400	0.135	24.000	3.600	10610	4295	371.3
16.00	3	400	0.180	32.000	4.800	7960	4295	660.0
20.00	3	400	0.220	40.000	6.000	6365	4200	1008.4

Thermoplastics



6.00	3	650	0.065	12.000	1.800	34485	6725	145.2
8.00	3	650	0.090	16.000	2.400	25865	6985	268.1
10.00	3	650	0.110	20.000	3.000	20690	6830	409.7
12.00	3	650	0.135	24.000	3.600	17240	6985	603.3
16.00	3	650	0.180	32.000	4.800	12930	6985	1072.6
20.00	3	650	0.220	40.000	6.000	10345	6830	1638.7



Wrought aluminium  
Construction aluminium



6.00	3	500	0.060	4.200	6.000	26525	4775	120.3
8.00	3	500	0.080	5.600	8.000	19895	4775	213.9
10.00	3	500	0.100	7.000	10.000	15915	4775	334.2
12.00	3	500	0.120	8.400	12.000	13265	4775	481.3
16.00	3	500	0.160	11.200	16.000	9945	4775	855.6
20.00	3	500	0.200	14.000	20.000	7960	4775	1336.9

Unalloyed copper



6.00	3	270	0.060	4.200	6.000	14325	2580	65.0
8.00	3	270	0.080	5.600	8.000	10745	2580	115.5
10.00	3	270	0.100	7.000	10.000	8595	2580	180.5
12.00	3	270	0.120	8.400	12.000	7160	2580	259.9
16.00	3	270	0.160	11.200	16.000	5370	2580	462.0
20.00	3	270	0.200	14.000	20.000	4295	2580	721.9

Thermoplastics



6.00	3	650	0.060	4.200	6.000	34485	6205	156.4
8.00	3	650	0.080	5.600	8.000	25865	6205	278.1
10.00	3	650	0.100	7.000	10.000	20690	6205	434.5
12.00	3	650	0.120	8.400	12.000	17240	6205	625.7
16.00	3	650	0.160	11.200	16.000	12930	6205	1112.3
20.00	3	650	0.200	14.000	20.000	10345	6205	1738.0