

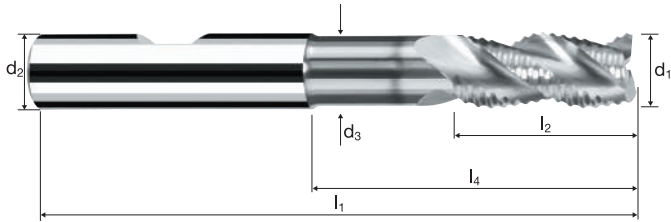
Cylindrical end mills AX

Profiled, medium length version, neck



HM
MG10

λ 40°
 γ 18°



Roughing

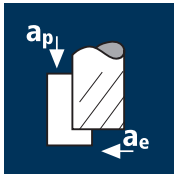
Finishing



Rm < 850		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Example: Order-N°.											CELERO	
											C15398	
											C15298	
\emptyset Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	45°	z			
300	6.00	6.00	5.50	63	13.00	25.34	26.00	0.40	3	●		
391	8.00	8.00	7.40	72	19.00	34.29	35.00	0.40	3	●		
450	10.00	10.00	9.20	84	22.00	42.20	43.00	0.40	3	●		
501	12.00	12.00	11.00	97	26.00	50.13	51.00	0.40	3	●		
610	16.00	16.00	15.00	108	32.00	58.13	59.00	0.50	3	●		
682	20.00	20.00	19.00	122	38.00	70.13	71.00	0.50	3	●		
772	25.00	25.00	24.00	144	45.00	86.13	87.00	0.70	3	●		

Application



Material

Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	3	600	0.065	9.000	2.400	31830	6205	134.1
8.00	3	600	0.090	12.000	3.200	23875	6445	247.5
10.00	3	600	0.110	15.000	4.000	19100	6305	378.2
12.00	3	600	0.135	18.000	4.800	15915	6445	556.9
16.00	3	600	0.180	24.000	6.400	11935	6445	990.1
20.00	3	600	0.220	30.000	8.000	9550	6305	1512.6
25.00	3	600	0.280	37.500	10.000	7640	6415	2406.4

6.00	3	400	0.065	9.000	2.400	21220	4140	89.4
8.00	3	400	0.090	12.000	3.200	15915	4295	165.0
10.00	3	400	0.110	15.000	4.000	12730	4200	252.1
12.00	3	400	0.135	18.000	4.800	10610	4295	371.3
16.00	3	400	0.180	24.000	6.400	7960	4295	660.0
20.00	3	400	0.220	30.000	8.000	6365	4200	1008.4
25.00	3	400	0.280	37.500	10.000	5095	4280	1604.3

6.00	3	792	0.065	9.000	2.400	42015	8195	177.0
8.00	3	800	0.090	12.000	3.200	31830	8595	330.0
10.00	3	800	0.110	15.000	4.000	25465	8405	504.2
12.00	3	800	0.135	18.000	4.800	21220	8595	742.6
16.00	3	800	0.180	24.000	6.400	15915	8595	1320.1
20.00	3	800	0.220	30.000	8.000	12730	8405	2016.8
25.00	3	800	0.280	37.500	10.000	10185	8555	3208.6

6.00	3	500	0.060	4.800	6.000	26525	4775	137.5
8.00	3	500	0.080	6.400	8.000	19895	4775	244.5
10.00	3	500	0.100	8.000	10.000	15915	4775	382.0
12.00	3	500	0.120	9.600	12.000	13265	4775	550.0
16.00	3	500	0.160	12.800	16.000	9945	4775	977.8
20.00	3	500	0.200	16.000	20.000	7960	4775	1527.9
25.00	3	500	0.250	20.000	25.000	6365	4775	2387.3

6.00	3	270	0.060	4.800	6.000	14325	2580	74.3
8.00	3	270	0.080	6.400	8.000	10745	2580	132.0
10.00	3	270	0.100	8.000	10.000	8595	2580	206.3
12.00	3	270	0.120	9.600	12.000	7160	2580	297.0
16.00	3	270	0.160	12.800	16.000	5370	2580	528.0
20.00	3	270	0.200	16.000	20.000	4295	2580	825.1
25.00	3	270	0.250	20.000	25.000	3440	2580	1289.2

6.00	3	792	0.060	4.800	6.000	42015	7565	217.8
8.00	3	800	0.080	6.400	8.000	31830	7640	391.1
10.00	3	800	0.100	8.000	10.000	25465	7640	611.2
12.00	3	800	0.120	9.600	12.000	21220	7640	880.1
16.00	3	800	0.160	12.800	16.000	15915	7640	1564.6
20.00	3	800	0.200	16.000	20.000	12730	7640	2444.6
25.00	3	800	0.250	20.000	25.000	10185	7640	3819.7