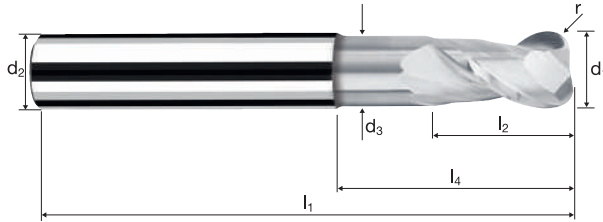
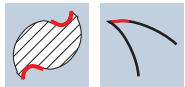
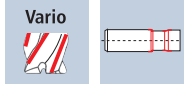


# Corner radius end mills AX

Smooth-edged, version 3xd, neck



HM  
MG10     $\lambda$  40°  
                   $\gamma$  20°

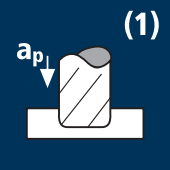

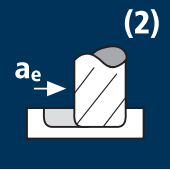

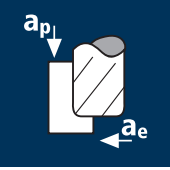

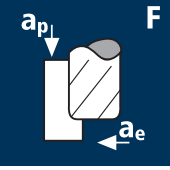





|  |  |                          |                          |                         |  |              |                        |  |
|--|--|--------------------------|--------------------------|-------------------------|--|--------------|------------------------|--|
|  |  | Al<br>Aluminium<br>> 99% | Al<br>Aluminium<br>Alloy | Al<br>Aluminium<br>Cast |  | Cu<br>Copper | Plastic<br>Thermoplast |  |
|--|--|--------------------------|--------------------------|-------------------------|--|--------------|------------------------|--|

|                    |                   |                   |                |                |                |                |                |              |      |   |   | CELERO                    |        |
|--------------------|-------------------|-------------------|----------------|----------------|----------------|----------------|----------------|--------------|------|---|---|---------------------------|--------|
| Example: Order-N°. |                   |                   |                |                |                |                |                |              |      |   |   | 15573                     | C15573 |
|                    |                   |                   |                |                |                |                |                |              |      |   |   | C 15573 180               |        |
|                    |                   |                   |                |                |                |                |                |              |      |   |   | Coating Article-N° ø-Code |        |
| Ø Code             | d <sub>1</sub> e8 | d <sub>2</sub> h6 | d <sub>3</sub> | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | l <sub>4</sub> | r<br>0/+0.03 | α    | z |   |                           |        |
| 180                | 3.00              | 6.00              | 2.80           | 54             | 4.00           | 9.00           | 15.37          | 0.500        | 5.9° | 2 | ● | ●                         |        |
| 220                | 4.00              | 6.00              | 3.70           | 54             | 5.00           | 12.00          | 16.82          | 0.500        | 3.7° | 2 | ● | ●                         |        |
| 260                | 5.00              | 6.00              | 4.60           | 54             | 6.00           | 15.00          | 18.27          | 0.500        | 1.7° | 2 | ● | ●                         |        |
| 300                | 6.00              | 6.00              | 5.50           | 54             | 7.00           | 16.15          | 18.00          | 0.500        | 0.0° | 2 | ● | ●                         |        |
| 302                | 6.00              | 6.00              | 5.50           | 54             | 7.00           | 16.15          | 18.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 391                | 8.00              | 8.00              | 7.40           | 63             | 9.00           | 21.63          | 24.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 450                | 10.00             | 10.00             | 9.20           | 72             | 11.00          | 26.99          | 30.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 501                | 12.00             | 12.00             | 11.00          | 83             | 13.00          | 32.29          | 36.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 608                | 16.00             | 16.00             | 15.00          | 97             | 18.00          | 43.73          | 48.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 680                | 20.00             | 20.00             | 19.00          | 111            | 22.00          | 55.23          | 60.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 770                | 25.00             | 25.00             | 24.00          | 132            | 27.00          | 69.68          | 75.00          | 1.000        | 0.0° | 2 | ● | ●                         |        |
| 453                | 10.00             | 10.00             | 9.20           | 72             | 11.00          | 26.99          | 30.00          | 1.500        | 0.0° | 2 | ● | -                         |        |
| 503                | 12.00             | 12.00             | 11.00          | 83             | 13.00          | 32.29          | 36.00          | 1.500        | 0.0° | 2 | ● | -                         |        |
| 611                | 16.00             | 16.00             | 15.00          | 97             | 18.00          | 43.73          | 48.00          | 2.000        | 0.0° | 2 | ● | -                         |        |
| 683                | 20.00             | 20.00             | 19.00          | 111            | 22.00          | 55.23          | 60.00          | 2.000        | 0.0° | 2 | ● | -                         |        |

| Application | Material  | d1<br>[mm] | z   | f <sub>z</sub><br>[mm] | a <sub>p</sub><br>[mm] | a <sub>e</sub><br>[mm] | n=10000 min <sup>-1</sup><br>vf [mm/min] | n=15000 min <sup>-1</sup><br>vf [mm/min] | n=20000 min <sup>-1</sup><br>vf [mm/min] | n=30000 min <sup>-1</sup><br>vf [mm/min] |
|-------------|---|------------|---|------------------------|------------------------|------------------------|--|--|--|--|
| <p>(1)</p>  | Wrought aluminium<br>Construction aluminium<br> | 3.00       | 2   | 0.050                  | 2.000                  | 3.000                  | 1000                                     | 1500                                     | 2000                                     | 3000                                     |
|             |   | 4.00       | 2   | 0.065                  | 3.000                  | 4.000                  | 1300                                     | 1950                                     | 2600                                     | 3900                                     |
|             |   | 6.00       | 2   | 0.100                  | 4.000                  | 6.000                  | 2000                                     | 3000                                     | 4000                                     | 6000                                     |
|             |   | 8.00       | 2   | 0.130                  | 5.000                  | 8.000                  | 2600                                     | 3900                                     | 5200                                     | 7800                                     |
|             |   | 10.00      | 2   | 0.165                  | 5.500                  | 10.000                 | 3300                                     | 4950                                     | 6600                                     | 9900                                     |
|             |   | 12.00      | 2   | 0.195                  | 6.000                  | 12.000                 | 3900                                     | 5850                                     | 7800                                     | 11700                                    |
|             |   | 16.00      | 2   | 0.210                  | 6.500                  | 16.000                 | 4200                                     | 6300                                     | 8400                                     | 12600                                    |
|             |   | 20.00      | 2   | 0.220                  | 7.000                  | 20.000                 | 4400                                     | 6600                                     | 8800                                     | 13200                                    |
|             |   | 25.00      | 2   | 0.230                  | 7.000                  | 25.000                 | 4600                                     | 6900                                     | 9200                                     | 13800                                    |
|             |   | <p>(2)</p> | Wrought aluminium<br>Construction aluminium<br> | 3.00                   | 2                      | 0.050                  | 2.000                                    | 2.400                                    | 1000                                     | 1500                                     |
| 4.00        | 2   |            |   | 0.065                  | 3.000                  | 3.200                  | 1300                                     | 1950                                     | 2600                                     | 3900                                     |
| 6.00        | 2   |            |   | 0.100                  | 4.000                  | 4.800                  | 2000                                     | 3000                                     | 4000                                     | 6000                                     |
| 8.00        | 2   |            |   | 0.130                  | 5.000                  | 6.400                  | 2600                                     | 3900                                     | 5200                                     | 7800                                     |
| 10.00       | 2   |            |   | 0.165                  | 5.500                  | 8.000                  | 3300                                     | 4950                                     | 6600                                     | 9900                                     |
| 12.00       | 2   |            |   | 0.195                  | 6.000                  | 9.600                  | 3900                                     | 5850                                     | 7800                                     | 11700                                    |
| 16.00       | 2   |            |   | 0.210                  | 6.500                  | 12.800                 | 4200                                     | 6300                                     | 8400                                     | 12600                                    |
| 20.00       | 2   |            |   | 0.220                  | 7.000                  | 16.000                 | 4400                                     | 6600                                     | 8800                                     | 13200                                    |
| 25.00       | 2   |            |   | 0.230                  | 7.000                  | 20.000                 | 4600                                     | 6900                                     | 9200                                     | 13800                                    |
| <p>F</p>    | Wrought aluminium<br>Construction aluminium<br> |            |   | 3.00                   | 2                      | 0.015                  | 3.000                                    | 0.100                                    | 300                                      | 450                                      |
|             |   | 4.00       | 2   | 0.020                  | 4.500                  | 0.100                  | 400                                      | 600                                      | 800                                      | 1200                                     |
|             |   | 6.00       | 2   | 0.030                  | 6.000                  | 0.200                  | 600                                      | 900                                      | 1200                                     | 1800                                     |
|             |   | 8.00       | 2   | 0.040                  | 7.500                  | 0.250                  | 800                                      | 1200                                     | 1600                                     | 2400                                     |
|             |   | 10.00      | 2   | 0.050                  | 8.300                  | 0.300                  | 1000                                     | 1500                                     | 2000                                     | 3000                                     |
|             |   | 12.00      | 2   | 0.060                  | 9.000                  | 0.350                  | 1200                                     | 1800                                     | 2400                                     | 3600                                     |
|             |   | 16.00      | 2   | 0.065                  | 9.800                  | 0.500                  | 1300                                     | 1950                                     | 2600                                     | 3900                                     |
|             |   | 20.00      | 2   | 0.065                  | 10.500                 | 0.600                  | 1300                                     | 1950                                     | 2600                                     | 3900                                     |
|             |   | 25.00      | 2   | 0.070                  | 10.500                 | 0.750                  | 1400                                     | 2100                                     | 2800                                     | 4200                                     |
|             |   |            | Wrought aluminium<br>Construction aluminium<br> | 3.00                   | 2                      | 0.110                  | 0.300                                    | 0.300                                    | 2200                                     | 3300                                     |
| 4.00        | 2   |            |   | 0.145                  | 0.350                  | 0.350                  | 2900                                     | 4350                                     | 5800                                     | 8700                                     |
| 6.00        | 2   |            |   | 0.220                  | 0.400                  | 0.400                  | 4400                                     | 6600                                     | 8800                                     | 13200                                    |
| 8.00        | 2   |            |   | 0.285                  | 0.450                  | 0.450                  | 5700                                     | 8550                                     | 11400                                    | 17100                                    |
| 10.00       | 2   |            |   | 0.365                  | 0.500                  | 0.500                  | 7300                                     | 10950                                    | 14600                                    | 21900                                    |
| 12.00       | 2   |            |   | 0.430                  | 0.600                  | 0.600                  | 8600                                     | 12900                                    | 17200                                    | 25800                                    |
| 16.00       | 2   |            |   | 0.460                  | 0.750                  | 0.750                  | 9200                                     | 13800                                    | 18400                                    | 27600                                    |
| 20.00       | 2   |            |   | 0.485                  | 1.000                  | 1.000                  | 9700                                     | 14550                                    | 19400                                    | 29100                                    |
| 25.00       | 2   |            |   | 0.505                  | 1.200                  | 1.200                  | 10100                                    | 15150                                    | 20200                                    | 30300                                    |



| Application   | Material   | d1<br>[mm] | z | f <sub>z</sub><br>[mm] | a <sub>p</sub><br>[mm] | a <sub>e</sub><br>[mm] | n=1000 min <sup>-1</sup><br>vf [mm/min] | n=1500 min <sup>-1</sup><br>vf [mm/min] | n=2000 min <sup>-1</sup><br>vf [mm/min] | n=3000 min <sup>-1</sup><br>vf [mm/min] |
|---|--|------------|---|------------------------|------------------------|------------------------|---|---|---|---|
|  <p>(1)</p> | Wrought aluminium<br>Construction aluminium<br><br> | 6.00       | 2 | 0.100                  | 4.000                  | 6.000                  | 2000                                    | 3000                                    | 4000                                    | 6000                                    |
|   |  | 8.00       | 2 | 0.130                  | 5.000                  | 8.000                  | 2600                                    | 3900                                    | 5200                                    | 7800                                    |
|   |  | 10.00      | 2 | 0.165                  | 5.500                  | 10.000                 | 3300                                    | 4950                                    | 6600                                    | 9900                                    |
|   |  | 12.00      | 2 | 0.195                  | 6.000                  | 12.000                 | 3900                                    | 5850                                    | 7800                                    | 11700                                   |
|   |  | 16.00      | 2 | 0.210                  | 6.500                  | 16.000                 | 4200                                    | 6300                                    | 8400                                    | 12600                                   |
|   |  | 20.00      | 2 | 0.220                  | 7.000                  | 20.000                 | 4400                                    | 6600                                    | 8800                                    | 13200                                   |
|   |  | 25.00      | 2 | 0.230                  | 7.000                  | 25.000                 | 4600                                    | 6900                                    | 9200                                    | 13800                                   |
|  <p>(2)</p> | Wrought aluminium<br>Construction aluminium<br><br> | 6.00       | 2 | 0.100                  | 4.000                  | 4.800                  | 2000                                    | 3000                                    | 4000                                    | 6000                                    |
|   |  | 8.00       | 2 | 0.130                  | 5.000                  | 6.400                  | 2600                                    | 3900                                    | 5200                                    | 7800                                    |
|   |  | 10.00      | 2 | 0.165                  | 5.500                  | 8.000                  | 3300                                    | 4950                                    | 6600                                    | 9900                                    |
|   |  | 12.00      | 2 | 0.195                  | 6.000                  | 9.600                  | 3900                                    | 5850                                    | 7800                                    | 11700                                   |
|   |  | 16.00      | 2 | 0.210                  | 6.500                  | 12.800                 | 4200                                    | 6300                                    | 8400                                    | 12600                                   |
|   |  | 20.00      | 2 | 0.220                  | 7.000                  | 16.000                 | 4400                                    | 6600                                    | 8800                                    | 13200                                   |
|   |  | 25.00      | 2 | 0.230                  | 7.000                  | 20.000                 | 4600                                    | 6900                                    | 9200                                    | 13800                                   |
|             | Wrought aluminium<br>Construction aluminium<br><br> | 6.00       | 2 | 0.100                  | 6.000                  | 3.600                  | 2000                                    | 3000                                    | 4000                                    | 6000                                    |
|   |  | 8.00       | 2 | 0.130                  | 7.500                  | 4.800                  | 2600                                    | 3900                                    | 5200                                    | 7800                                    |
|   |  | 10.00      | 2 | 0.165                  | 8.300                  | 6.000                  | 3300                                    | 4950                                    | 6600                                    | 9900                                    |
|   |  | 12.00      | 2 | 0.195                  | 9.000                  | 7.200                  | 3900                                    | 5850                                    | 7800                                    | 11700                                   |
|   |  | 16.00      | 2 | 0.210                  | 9.800                  | 9.600                  | 4200                                    | 6300                                    | 8400                                    | 12600                                   |
|   |  | 20.00      | 2 | 0.220                  | 10.500                 | 12.000                 | 4400                                    | 6600                                    | 8800                                    | 13200                                   |
|   |  | 25.00      | 2 | 0.230                  | 10.500                 | 15.000                 | 4600                                    | 6900                                    | 9200                                    | 13800                                   |
|  <p>F</p>   | Wrought aluminium<br>Construction aluminium<br><br> | 6.00       | 2 | 0.030                  | 6.000                  | 0.200                  | 600                                     | 900                                     | 1200                                    | 1800                                    |
|   |  | 8.00       | 2 | 0.040                  | 7.500                  | 0.250                  | 800                                     | 1200                                    | 1600                                    | 2400                                    |
|   |  | 10.00      | 2 | 0.050                  | 8.300                  | 0.300                  | 1000                                    | 1500                                    | 2000                                    | 3000                                    |
|   |  | 12.00      | 2 | 0.060                  | 9.000                  | 0.350                  | 1200                                    | 1800                                    | 2400                                    | 3600                                    |
|   |  | 16.00      | 2 | 0.065                  | 9.800                  | 0.500                  | 1300                                    | 1950                                    | 2600                                    | 3900                                    |
|   |  | 20.00      | 2 | 0.065                  | 10.500                 | 0.600                  | 1300                                    | 1950                                    | 2600                                    | 3900                                    |
|   |  | 25.00      | 2 | 0.070                  | 10.500                 | 0.750                  | 1400                                    | 2100                                    | 2800                                    | 4200                                    |
|            | Wrought aluminium<br>Construction aluminium<br><br> | 6.00       | 2 | 0.220                  | 0.400                  | 0.400                  | 4400                                    | 6600                                    | 8800                                    | 13200                                   |
|   |  | 8.00       | 2 | 0.285                  | 0.450                  | 0.450                  | 5700                                    | 8550                                    | 11400                                   | 17100                                   |
|   |  | 10.00      | 2 | 0.365                  | 0.500                  | 0.500                  | 7300                                    | 10950                                   | 14600                                   | 21900                                   |
|   |  | 12.00      | 2 | 0.430                  | 0.600                  | 0.600                  | 8600                                    | 12900                                   | 17200                                   | 25800                                   |
|   |  | 16.00      | 2 | 0.460                  | 0.750                  | 0.750                  | 9200                                    | 13800                                   | 18400                                   | 27600                                   |
|   |  | 20.00      | 2 | 0.485                  | 1.000                  | 1.000                  | 9700                                    | 14550                                   | 19400                                   | 29100                                   |
|   |  | 25.00      | 2 | 0.505                  | 1.200                  | 1.200                  | 10100                                   | 15150                                   | 20200                                   | 30300                                   |