

# Corner radius end mills AX

Smooth-edged, version 4xd, neck

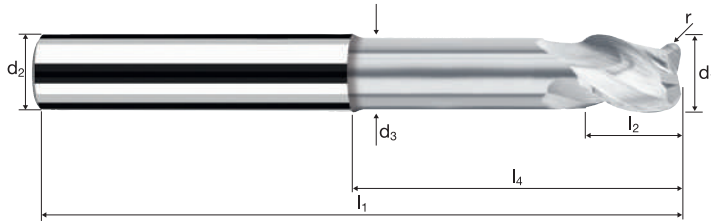


**HM**  
**MG10**

$\lambda$  40°  
 $\gamma$  20°

**G2.5**

**Vario**

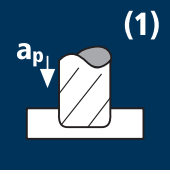

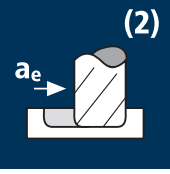

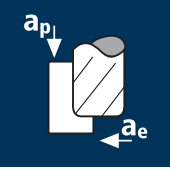

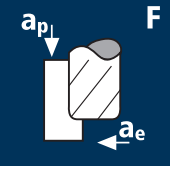





**Roughing** **Finishing**

**ToolSchool** 15585 / C15585

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

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 0/+0.03	z	CELERO	
										15584	C15584
Example: Order-N°: <b>C</b> <b>15584</b> <b>302</b>											
302	6.00	6.00	5.50	60	7.00	22.15	24.00	1.000	3	●	●
391	8.00	8.00	7.40	68	9.00	29.63	32.00	1.000	3	●	●
450	10.00	10.00	9.20	84	11.00	36.99	40.00	1.000	3	●	●
501	12.00	12.00	11.00	97	13.00	44.29	48.00	1.000	3	●	●
608	16.00	16.00	15.00	115	18.00	59.73	64.00	1.000	3	●	●
680	20.00	20.00	19.00	130	22.00	75.23	80.00	1.000	3	●	●
770	25.00	25.00	24.00	157	27.00	94.68	100.00	1.000	3	●	●
307	6.00	6.00	5.50	60	7.00	22.15	24.00	2.500	3	●	●
397	8.00	8.00	7.40	68	9.00	29.63	32.00	2.500	3	●	●
457	10.00	10.00	9.20	84	11.00	36.99	40.00	2.500	3	●	●
506	12.00	12.00	11.00	97	13.00	44.29	48.00	2.500	3	●	●
612	16.00	16.00	15.00	115	18.00	59.73	64.00	2.500	3	●	●
684	20.00	20.00	19.00	130	22.00	75.23	80.00	2.500	3	●	●
774	25.00	25.00	24.00	157	27.00	94.68	100.00	2.500	3	●	●
459	10.00	10.00	9.20	84	11.00	36.99	40.00	4.000	3	●	●
508	12.00	12.00	11.00	97	13.00	44.29	48.00	4.000	3	●	●
614	16.00	16.00	15.00	115	18.00	59.73	64.00	4.000	3	●	●
686	20.00	20.00	19.00	130	22.00	75.23	80.00	4.000	3	●	●
776	25.00	25.00	24.00	157	27.00	94.68	100.00	4.000	3	●	●

Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=1000 min <sup>-1</sup> vf [mm/min]	n=1500 min <sup>-1</sup> vf [mm/min]	n=2000 min <sup>-1</sup> vf [mm/min]	n=3000 min <sup>-1</sup> vf [mm/min]
 <p>(1)</p>	Wrought aluminium Construction aluminium  	6.00	3	0.060	3.500	6.000	1800	2700	3600	5400
		8.00	3	0.075	4.500	8.000	2250	3375	4500	6750
		10.00	3	0.095	5.000	10.000	2850	4275	5700	8550
		12.00	3	0.115	5.500	12.000	3450	5175	6900	10350
		16.00	3	0.125	6.000	16.000	3750	5625	7500	11250
		20.00	3	0.130	6.500	20.000	3900	5850	7800	11700
		25.00	3	0.140	6.500	25.000	4200	6300	8400	12600
 <p>(2)</p>	Wrought aluminium Construction aluminium  	6.00	3	0.060	3.500	3.600	1800	2700	3600	5400
		8.00	3	0.075	4.500	4.800	2250	3375	4500	6750
		10.00	3	0.095	5.000	6.000	2850	4275	5700	8550
		12.00	3	0.115	5.500	7.200	3450	5175	6900	10350
		16.00	3	0.125	6.000	9.600	3750	5625	7500	11250
		20.00	3	0.130	6.500	12.000	3900	5850	7800	11700
		25.00	3	0.140	6.500	15.000	4200	6300	8400	12600
	Wrought aluminium Construction aluminium  	6.00	3	0.060	5.300	3.600	1800	2700	3600	5400
		8.00	3	0.075	6.800	4.800	2250	3375	4500	6750
		10.00	3	0.095	7.500	6.000	2850	4275	5700	8550
		12.00	3	0.115	8.300	7.200	3450	5175	6900	10350
		16.00	3	0.125	9.000	9.600	3750	5625	7500	11250
		20.00	3	0.130	9.800	12.000	3900	5850	7800	11700
		25.00	3	0.140	9.800	15.000	4200	6300	8400	12600
 <p>F</p>	Wrought aluminium Construction aluminium  	6.00	3	0.020	5.300	0.200	600	900	1200	1800
		8.00	3	0.025	6.800	0.250	750	1125	1500	2250
		10.00	3	0.030	7.500	0.300	900	1350	1800	2700
		12.00	3	0.035	8.300	0.350	1050	1575	2100	3150
		16.00	3	0.040	9.000	0.500	1200	1800	2400	3600
		20.00	3	0.040	9.800	0.600	1200	1800	2400	3600
		25.00	3	0.040	9.800	0.750	1200	1800	2400	3600
	Wrought aluminium Construction aluminium  	6.00	3	0.130	0.350	0.350	3900	5850	7800	11700
		8.00	3	0.165	0.400	0.400	4950	7425	9900	14850
		10.00	3	0.210	0.450	0.450	6300	9450	12600	18900
		12.00	3	0.255	0.500	0.500	7650	11475	15300	22950
		16.00	3	0.275	0.600	0.600	8250	12375	16500	24750
		20.00	3	0.285	0.750	0.750	8550	12825	17100	25650
		25.00	3	0.310	0.800	0.800	9300	13950	18600	27900