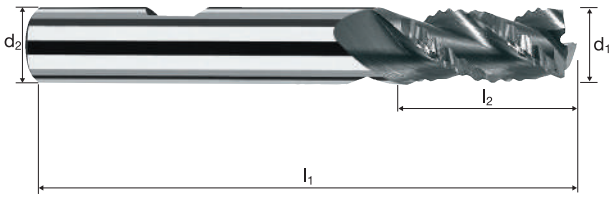
Cylindrical end mills AX

Profiled, normal version

X-Generation

HM MG10	λ 40° γ 18°

45°



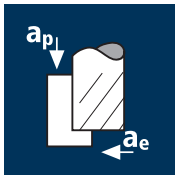
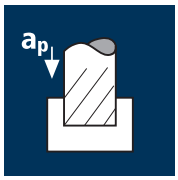
Roughing

Finishing

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

Example: **Order-N°.** Coating **C** Article-N°. **5397** ø-Code **300**

Ø Code	d_1 e8	d_2 h6	l_1	l_2	45°	z	CELERO C5397	CELERO C5297
300	6.00	6.00	57	13.00	0.40	3		●
391	8.00	8.00	63	19.00	0.40	3		●
450	10.00	10.00	72	22.00	0.40	3		●
501	12.00	12.00	83	26.00	0.40	3		●
610	16.00	16.00	92	32.00	0.50	3		●
682	20.00	20.00	104	38.00	0.50	3		●

Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min-1]	v_f [mm/min]	Q [cm³/min]
	Wrought aluminium Construction aluminium	6.00	3	600	0.065	9.000	3.600	31830	6205	201.1
		8.00	3	600	0.090	12.000	4.800	23875	6445	371.3
		10.00	3	600	0.110	15.000	6.000	19100	6305	567.2
		12.00	3	600	0.135	18.000	7.200	15915	6445	835.4
		16.00	3	600	0.180	24.000	9.600	11935	6445	1485.1
		20.00	3	600	0.220	30.000	12.000	9550	6305	2268.9
	Unalloyed copper	6.00	3	400	0.065	9.000	3.600	21220	4140	134.1
		8.00	3	400	0.090	12.000	4.800	15915	4295	247.5
		10.00	3	400	0.110	15.000	6.000	12730	4200	378.2
		12.00	3	400	0.135	18.000	7.200	10610	4295	556.9
		16.00	3	400	0.180	24.000	9.600	7960	4295	990.1
		20.00	3	400	0.220	30.000	12.000	6365	4200	1512.6
	Thermoplastics	6.00	3	650	0.065	9.000	3.600	34485	6725	217.9
		8.00	3	650	0.090	12.000	4.800	25865	6985	402.2
		10.00	3	650	0.110	15.000	6.000	20690	6830	614.5
		12.00	3	650	0.135	18.000	7.200	17240	6985	905.0
		16.00	3	650	0.180	24.000	9.600	12930	6985	1608.9
		20.00	3	650	0.220	30.000	12.000	10345	6830	2458.0
	Wrought aluminium Construction aluminium	6.00	3	500	0.060	9.000	6.000	26525	4775	257.8
		8.00	3	500	0.080	12.000	8.000	19895	4775	458.4
		10.00	3	500	0.100	15.000	10.000	15915	4775	716.2
		12.00	3	500	0.120	18.000	12.000	13265	4775	1031.3
		16.00	3	500	0.160	24.000	16.000	9945	4775	1833.5
		20.00	3	500	0.200	30.000	20.000	7960	4775	2864.8
	Unalloyed copper	6.00	3	270	0.060	9.000	6.000	14325	2580	139.2
		8.00	3	270	0.080	12.000	8.000	10745	2580	247.5
		10.00	3	270	0.100	15.000	10.000	8595	2580	386.7
		12.00	3	270	0.120	18.000	12.000	7160	2580	556.9
		16.00	3	270	0.160	24.000	16.000	5370	2580	990.1
		20.00	3	270	0.200	30.000	20.000	4295	2580	1547.0
	Thermoplastics	6.00	3	650	0.060	9.000	6.000	34485	6205	335.2
		8.00	3	650	0.080	12.000	8.000	25865	6205	595.9
		10.00	3	650	0.100	15.000	10.000	20690	6205	931.1
		12.00	3	650	0.120	18.000	12.000	17240	6205	1340.7
		16.00	3	650	0.160	24.000	16.000	12930	6205	2383.5
		20.00	3	650	0.200	30.000	20.000	10345	6205	3724.2