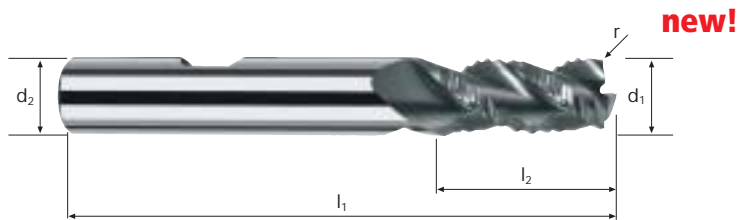


Corner radius end mills AX-RFP

Profiled, normal version



HM
MG10 λ 40°
 γ 18°



Roughing



Finishing



Rm
< 850

Al
Aluminium
> 99%

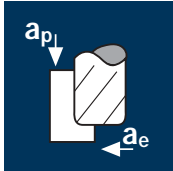





Al
Aluminium
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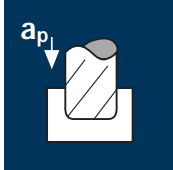





Al
Aluminium
Cast

Cu
Copper

Plastic
Thermoplast

| | | | | | | | CELERO | |
|-----------------------|----------|----------|-----|----|--------------|---|--------|--------|
| Example: Order-N°. | | | | | | | 15377 | C15377 |
| | | | | | | | 15277 | C15277 |
| \emptyset Code | d1 e8 | d2 h6 | l1 | l2 | r 0/+0,03 | Z | | |
| .612 | 16 | 16 | 92 | 32 | 2.5 | 3 | ● | ● |
| .684 | 20 | 20 | 104 | 38 | 2.5 | 3 | ● | ● |
| .614 | 16 | 16 | 92 | 32 | 4.0 | 3 | ● | ● |
| .686 | 20 | 20 | 104 | 38 | 4.0 | 3 | ● | ● |
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| 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 [cm ³ /min] | |
|--|---|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|--------------------------|--|
|  | Wrought aluminium alloys Si < 6%   | 16 | 3 | 600 | 0.190 | 24 | 9.6 | 11935 | 6805 | 1568.0 | |
| | | 20 | 3 | 600 | 0.235 | 30 | 12.0 | 9550 | 6735 | 2424.5 | |
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| | Unalloyed copper   | 16 | 3 | 400 | 0.190 | 24 | 9.6 | 7960 | 4535 | 1045.0 | |
| | | 20 | 3 | 400 | 0.235 | 30 | 12.0 | 6365 | 4485 | 1614.5 | |
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| | Thermoplastics  | 16 | 3 | 800 | 0.190 | 24 | 9.6 | 15915 | 9070 | 2089.5 | |
| | | 20 | 3 | 800 | 0.235 | 30 | 12.0 | 12735 | 8980 | 3233.0 | |
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| 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 [cm ³ /min] | |
|---|---|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|--------------------------|--|
|  | Wrought aluminium alloys Si < 6%   | 16 | 3 | 500 | 0.170 | 24.0 | 16 | 9945 | 5070 | 1947.0 | |
| | | 20 | 3 | 500 | 0.210 | 30.0 | 20 | 7960 | 5015 | 3009.0 | |
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| | Unalloyed copper   | 16 | 3 | 270 | 0.170 | 24.0 | 16 | 5370 | 2740 | 1052.0 | |
| | | 20 | 3 | 270 | 0.210 | 30.0 | 20 | 4295 | 2705 | 1623.0 | |
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| | Thermoplastics  | 16 | 3 | 800 | 0.170 | 24.0 | 16 | 15915 | 8115 | 3116.0 | |
| | | 20 | 3 | 800 | 0.210 | 30.0 | 20 | 12735 | 8025 | 4815.0 | |
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