

Corner radius end mills AX

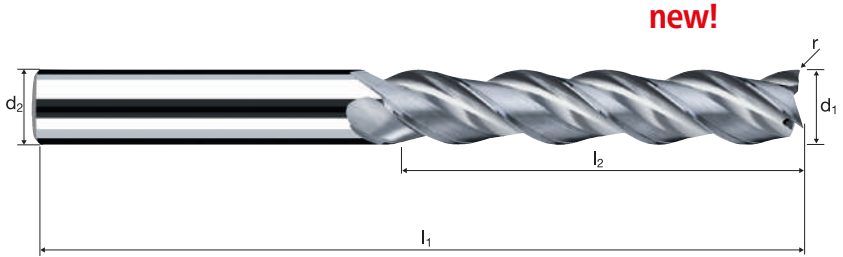
Finishing, extra-long version 5.2xd



HM
MG10 λ 40°
 γ 20°

G 2.5



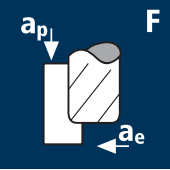

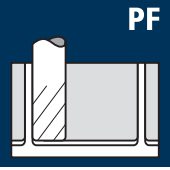

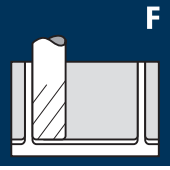



Vario



Roughing Finishing

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

Example: Order-N°.		Coating		Article-N°.		ø-Code			
				15512		302			
								15512	
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	r	z			
302	6.00	6.00	73	32.00	1.000	3	●	■	
391	8.00	8.00	84	42.00	1.000	3	●	■	
450	10.00	10.00	100	53.00	1.000	3	●	■	
501	12.00	12.00	117	63.00	1.000	3	●	■	
608	16.00	16.00	144	84.00	1.000	3	●	■	
457	10.00	10.00	100	53.00	2.500	3	●	■	
506	12.00	12.00	117	63.00	2.500	3	●	■	
612	16.00	16.00	144	84.00	2.500	3	●	■	
684	20.00	20.00	169	105.00	2.500	3	●	■	
■ Availability and delivery dates on request.									

Application	Material	d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
	Wrought aluminium Construction aluminium 	6.00	3	300	0.025	32.000	0.080	15915	1195
		8.00	3	300	0.030	42.000	0.100	11935	1075
		10.00	3	350	0.030	53.000	0.120	11140	1005
		12.00	3	350	0.030	63.000	0.120	9285	835
		16.00	3	400	0.035	84.000	0.150	7960	835
		20.00	3	400	0.035	105.000	0.150	6365	670
	Wrought aluminium Construction aluminium 	6.00	3	200	0.020	32.000	0.030	10610	635
		8.00	3	200	0.025	42.000	0.050	7960	595
		10.00	3	250	0.025	53.000	0.050	7960	595
		12.00	3	250	0.025	63.000	0.050	6630	495
		16.00	3	300	0.030	84.000	0.050	5970	535
		20.00	3	300	0.030	105.000	0.050	4775	430
	Wrought aluminium Construction aluminium 	6.00	3	200	0.025	32.000	0.060	10610	795
		8.00	3	200	0.030	42.000	0.060	7960	715
		10.00	3	250	0.030	53.000	0.080	7960	715
		12.00	3	250	0.030	63.000	0.080	6630	595
		16.00	3	300	0.035	84.000	0.100	5970	625
		20.00	3	300	0.035	105.000	0.100	4775	500
	Wrought aluminium Construction aluminium 	6.00	3	150	0.020	32.000	0.030	7960	475
		8.00	3	150	0.025	42.000	0.030	5970	450
		10.00	3	200	0.025	53.000	0.040	6365	475
		12.00	3	200	0.025	63.000	0.040	5305	400
		16.00	3	250	0.030	84.000	0.050	4975	450
		20.00	3	250	0.030	105.000	0.050	3980	360
	Unalloyed copper 	6.00	3	90	0.020	32.000	0.030	4775	285
		8.00	3	90	0.025	42.000	0.030	3580	270
		10.00	3	120	0.025	53.000	0.040	3820	285
		12.00	3	120	0.025	63.000	0.040	3185	240
		16.00	3	150	0.030	84.000	0.050	2985	270
		20.00	3	150	0.030	105.000	0.050	2385	215