

Cylindrical end mills AX

Smooth-edged, medium length version, short neck

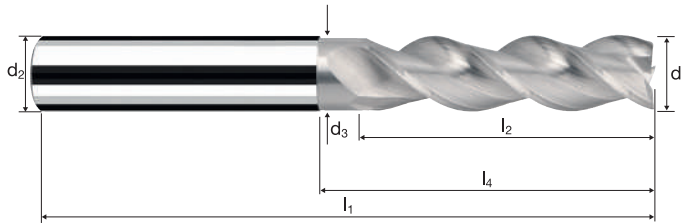


HM
MG10

λ 40°
 γ 20°

90°

Vario



Rm
 < 850

Al
 Aluminium > 99%

Al
 Aluminium Alloy

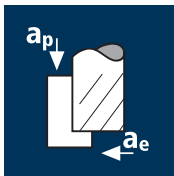
Al
 Aluminium Cast

Cu
 Copper

Plastic
 Thermoplast

										CELERO	
Example: Order-N°.										15660	C15660
										15560	C15560
\emptyset Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	α	z		
180	3.00	6.00	2.80	63	14.00	20.00	26.63	3.5°	3	●	●
220	4.00	6.00	3.70	63	17.00	22.00	26.95	2.5°	3	●	●
260	5.00	6.00	4.60	63	19.00	24.00	27.27	1.5°	3	●	●
300	6.00	6.00	5.50	63	19.00	25.34	26.00	0.0°	3	●	●
391	8.00	8.00	7.40	72	28.00	34.29	35.00	0.0°	3	●	●
450	10.00	10.00	9.20	84	34.00	42.20	43.00	0.0°	3	●	●
501	12.00	12.00	11.00	97	40.00	50.13	51.00	0.0°	3	●	●
610	16.00	16.00	15.00	108	48.00	58.13	59.00	0.0°	3	●	●
682	20.00	20.00	19.00	122	56.00	70.13	71.00	0.0°	3	●	●

Application



Material

Wrought aluminium
Construction aluminium



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
3.00	3	396	0.035	7.500	0.600	42015	4410	19.9
4.00	3	528	0.045	10.000	0.800	42015	5670	45.4
5.00	3	550	0.060	12.500	1.000	35015	6305	78.8
6.00	3	550	0.075	15.000	1.200	29180	6565	118.2
8.00	3	550	0.095	20.000	1.600	21885	6235	199.6
10.00	3	550	0.115	25.000	2.000	17505	6040	302.0
12.00	3	550	0.140	30.000	2.400	14590	6125	441.2
16.00	3	550	0.150	40.000	3.200	10940	4925	630.3
20.00	3	550	0.175	50.000	4.000	8755	4595	919.1

Unalloyed copper



3.00	3	396	0.030	7.500	0.600	42015	3780	17.0
4.00	3	400	0.035	10.000	0.800	31830	3340	26.7
5.00	3	400	0.050	12.500	1.000	25465	3820	47.7
6.00	3	400	0.060	15.000	1.200	21220	3820	68.8
8.00	3	400	0.075	20.000	1.600	15915	3580	114.6
10.00	3	400	0.090	25.000	2.000	12730	3440	171.9
12.00	3	400	0.110	30.000	2.400	10610	3500	252.1
16.00	3	400	0.120	40.000	3.200	7960	2865	366.7
20.00	3	400	0.140	50.000	4.000	6365	2675	534.8

Thermoplastics



3.00	3	396	0.035	7.500	0.600	42015	4410	19.9
4.00	3	528	0.045	10.000	0.800	42015	5670	45.4
5.00	3	660	0.060	12.500	1.000	42015	7565	94.5
6.00	3	792	0.075	15.000	1.200	42015	9455	170.2
8.00	3	1000	0.095	20.000	1.600	39790	11340	362.9
10.00	3	1000	0.115	25.000	2.000	31830	10980	549.1
12.00	3	1000	0.140	30.000	2.400	26525	11140	802.1
16.00	3	1000	0.150	40.000	3.200	19895	8950	1145.9
20.00	3	1000	0.175	50.000	4.000	15915	8355	1671.1

Cast aluminium



3.00	3	396	0.035	7.500	0.600	42015	4410	19.9
4.00	3	440	0.045	10.000	0.800	35015	4725	37.8
5.00	3	440	0.060	12.500	1.000	28010	5040	63.0
6.00	3	440	0.075	15.000	1.200	23345	5250	94.5
8.00	3	440	0.095	20.000	1.600	17505	4990	159.7
10.00	3	440	0.115	25.000	2.000	14005	4830	241.6
12.00	3	440	0.140	30.000	2.400	11670	4900	352.9
16.00	3	440	0.150	40.000	3.200	8755	3940	504.2
20.00	3	440	0.175	50.000	4.000	7005	3675	735.3



Wrought aluminium
Construction aluminium



3.00	3	396	0.025	1.200	3.000	42015	3150	11.3
4.00	3	450	0.030	1.600	4.000	35810	3225	20.6
5.00	3	450	0.040	2.000	5.000	28650	3440	34.4
6.00	3	450	0.055	2.400	6.000	23875	3940	56.7
8.00	3	450	0.065	3.200	8.000	17905	3490	89.4
10.00	3	450	0.080	4.000	10.000	14325	3440	137.5
12.00	3	450	0.100	4.800	12.000	11935	3580	206.3
16.00	3	450	0.105	6.400	16.000	8950	2820	288.8
20.00	3	450	0.125	8.000	20.000	7160	2685	429.7

Unalloyed copper



3.00	3	350	0.020	1.200	3.000	37135	2230	8.0
4.00	3	350	0.025	1.600	4.000	27850	2090	13.4
5.00	3	350	0.030	2.000	5.000	22280	2005	20.1
6.00	3	350	0.045	2.400	6.000	18570	2505	36.1
8.00	3	350	0.050	3.200	8.000	13925	2090	53.5
10.00	3	350	0.065	4.000	10.000	11140	2170	86.9
12.00	3	350	0.080	4.800	12.000	9285	2230	128.3
16.00	3	350	0.085	6.400	16.000	6965	1775	181.8
20.00	3	350	0.100	8.000	20.000	5570	1670	267.4

Thermoplastics



3.00	3	396	0.025	1.200	3.000	42015	3150	11.3
4.00	3	528	0.030	1.600	4.000	42015	3780	24.2
5.00	3	660	0.040	2.000	5.000	42015	5040	50.4
6.00	3	792	0.055	2.400	6.000	42015	6935	99.8
8.00	3	800	0.065	3.200	8.000	31830	6205	158.9
10.00	3	800	0.080	4.000	10.000	25465	6110	244.5
12.00	3	800	0.100	4.800	12.000	21220	6365	366.7
16.00	3	800	0.105	6.400	16.000	15915	5015	513.4
20.00	3	800	0.125	8.000	20.000	12730	4775	763.9

Cast aluminium



3.00	3	360	0.025	1.200	3.000	38195	2865	10.3
4.00	3	360	0.030	1.600	4.000	28650	2580	16.5
5.00	3	360	0.040	2.000	5.000	22920	2750	27.5
6.00	3	360	0.055	2.400	6.000	19100	3150	45.4
8.00	3	360	0.065	3.200	8.000	14325	2795	71.5
10.00	3	360	0.080	4.000	10.000	11460	2750	110.0
12.00	3	360	0.100	4.800	12.000	9550	2865	165.0
16.00	3	360	0.105	6.400	16.000	7160	2255	231.0
20.00	3	360	0.125	8.000	20.000	5730	2150	343.8