

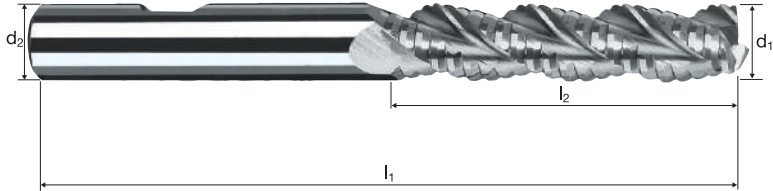
Cylindrical end mills

Profiled, medium length version

HSS

HSS-E
Co8

40°
18°



Roughing

Finishing



Rm
< 850

Al
Aluminium
> 99%

Al
Aluminium
Alloy

Cu
Copper

Plastic
Thermoplast

Example:
Order-N°.

Coating
C

Article-N°.
0393

ø-Code
450

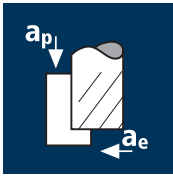


CELERO

C0393

Ø Code	d ₁ k8	d ₂ h6	l ₁	l ₂	45°	z	
450	10.00	10.00	95	45.00	0.40	3	●
501	12.00	12.00	110	53.00	0.40	3	●
610	16.00	16.00	123	63.00	0.50	3	●
682	20.00	20.00	141	75.00	0.50	3	●
772	25.00	25.00	166	90.00	0.70	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]
10.00	3	173	0.060	30.000	2.000	5505	990	59.5
12.00	3	173	0.090	36.000	2.400	4590	1240	107.1
16.00	3	173	0.120	48.000	3.200	3440	1240	190.3
20.00	3	173	0.145	60.000	4.000	2755	1200	287.5
25.00	3	173	0.185	75.000	5.000	2205	1225	458.4

Unalloyed copper



10.00	3	73	0.060	30.000	2.000	2325	420	25.1
12.00	3	73	0.090	36.000	2.400	1935	525	45.2
16.00	3	73	0.120	48.000	3.200	1450	525	80.3
20.00	3	73	0.145	60.000	4.000	1160	505	121.3
25.00	3	73	0.185	75.000	5.000	930	515	193.4

Thermoplastics



10.00	3	183	0.060	30.000	2.000	5825	1050	62.9
12.00	3	183	0.090	36.000	2.400	4855	1310	113.2
16.00	3	183	0.120	48.000	3.200	3640	1310	201.3
20.00	3	183	0.145	60.000	4.000	2915	1265	304.1
25.00	3	183	0.185	75.000	5.000	2330	1295	484.9



Wrought aluminium
Construction aluminium



10.00	3	157	0.050	5.000	10.000	4995	750	37.5
12.00	3	157	0.070	6.000	12.000	4165	875	63.0
16.00	3	157	0.095	8.000	16.000	3125	890	113.9
20.00	3	157	0.120	10.000	20.000	2500	900	179.9
25.00	3	157	0.145	12.500	25.000	2000	870	271.7

Unalloyed copper



10.00	3	68	0.050	5.000	10.000	2165	325	16.2
12.00	3	68	0.070	6.000	12.000	1805	380	27.3
16.00	3	68	0.095	8.000	16.000	1355	385	49.4
20.00	3	68	0.120	10.000	20.000	1080	390	77.9
25.00	3	68	0.145	12.500	25.000	865	375	117.7

Thermoplastics



10.00	3	168	0.050	5.000	10.000	5350	800	40.1
12.00	3	168	0.070	6.000	12.000	4455	935	67.4
16.00	3	168	0.095	8.000	16.000	3340	955	121.9
20.00	3	168	0.120	10.000	20.000	2675	965	192.5
25.00	3	168	0.145	12.500	25.000	2140	930	290.8