

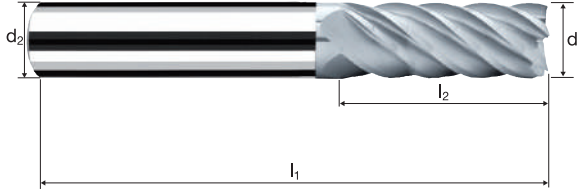
Cylindrical end mills MulticutXA

Finishing, normal version



HM
MG10 λ 40°
 γ 20°

r
G 2.5

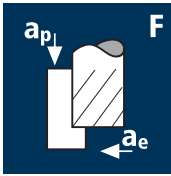


Roughing Finishing

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

								CELERO	
Example: Order-N°.								15589	C15589
								CELERO	
								15589	C15589
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	r	z			
300	6.00	6.00	57	13.00	0.150	6	●	●	
391	8.00	8.00	63	19.00	0.150	6	●	●	
450	10.00	10.00	72	22.00	0.200	6	●	●	
501	12.00	12.00	83	26.00	0.200	6	●	●	
610	16.00	16.00	92	32.00	0.200	6	●	●	
682	20.00	20.00	104	40.00	0.200	6	●	●	

Application



Material

Wrought aluminium
Construction aluminium



Unalloyed copper



Thermoplastics



Cast aluminium



d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	6	0.020	12.000	0.100	1200	1800	2400	3600
8.00	6	0.020	16.000	0.100	1200	1800	2400	3600
10.00	6	0.025	20.000	0.150	1500	2250	3000	4500
12.00	6	0.025	24.000	0.200	1500	2250	3000	4500
16.00	6	0.030	32.000	0.250	1800	2700	3600	5400
20.00	6	0.030	40.000	0.300	1800	2700	3600	5400
6.00	6	0.020	12.000	0.100	1200	1800	2400	3600
8.00	6	0.020	16.000	0.100	1200	1800	2400	3600
10.00	6	0.025	20.000	0.150	1500	2250	3000	4500
12.00	6	0.025	24.000	0.200	1500	2250	3000	4500
16.00	6	0.030	32.000	0.250	1800	2700	3600	5400
20.00	6	0.030	40.000	0.300	1800	2700	3600	5400
6.00	6	0.020	12.000	0.100	1200	1800	2400	3600
8.00	6	0.020	16.000	0.100	1200	1800	2400	3600
10.00	6	0.025	20.000	0.150	1500	2250	3000	4500
12.00	6	0.025	24.000	0.200	1500	2250	3000	4500
16.00	6	0.030	32.000	0.250	1800	2700	3600	5400
20.00	6	0.030	40.000	0.300	1800	2700	3600	5400