

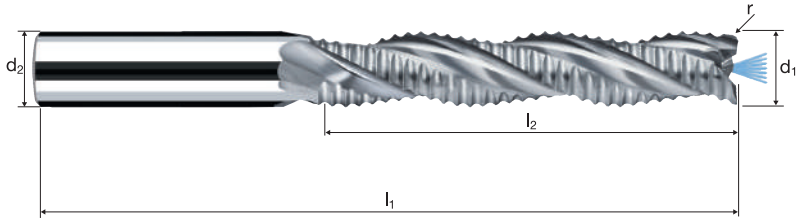
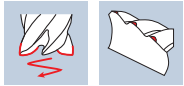
Cylindrical end mills AX-FPS

Profiled, extra-long version 5.2xd
High-performance penetration edge, central cooling channel



HM
MG10 λ 30°
 γ 20°

r
G 2,5

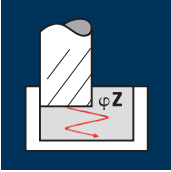


Roughing Finishing

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

| | | | | | | | Example: Order-N°. | | Coating | | Article-N°. | | ø-Code | | z | |
|--------|-------------------|-------------------|----------------|----------------|-------|---|--------------------|--|---------|--|-------------|--|--------|--|-------|--|
| | | | | | | | | | | | 15507 | | 300 | | 15607 | |
| | | | | | | | | | | | | | | | 15507 | |
| Ø Code | d ₁ e8 | d ₂ h5 | l ₁ | l ₂ | r | z | | | | | | | | | | |
| 300 | 6.00 | 6.00 | 73 | 32.00 | 0.100 | 3 | ● | | | | | | | | | |
| 391 | 8.00 | 8.00 | 84 | 42.00 | 0.150 | 3 | ● | | | | | | | | | |
| 450 | 10.00 | 10.00 | 100 | 53.00 | 0.200 | 3 | ● | | | | | | | | | |
| 501 | 12.00 | 12.00 | 117 | 63.00 | 0.200 | 3 | ● | | | | | | | | | |
| 610 | 16.00 | 16.00 | 144 | 84.00 | 0.200 | 3 | ● | | | | | | | | | |
| 682 | 20.00 | 20.00 | 169 | 105.00 | 0.200 | 3 | ● | | | | | | | | | |
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Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper

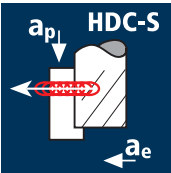


| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _r [mm/min] | φZ [°] |
|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------|
| 6.00 | 3 | 300 | 0.065 | 32.000 | 5.400 | 15915 | 3105 | 5° |
| 8.00 | 3 | 300 | 0.080 | 42.000 | 7.200 | 11935 | 2865 | 5° |
| 10.00 | 3 | 350 | 0.095 | 53.000 | 9.000 | 11140 | 3175 | 5° |
| 12.00 | 3 | 350 | 0.110 | 63.000 | 10.800 | 9285 | 3065 | 5° |
| 16.00 | 3 | 400 | 0.130 | 84.000 | 14.400 | 7960 | 3105 | 5° |
| 20.00 | 3 | 400 | 0.145 | 105.000 | 18.000 | 6365 | 2770 | 5° |

| | | | | | | | | |
|-------|---|-----|-------|---------|--------|-------|------|----|
| 6.00 | 3 | 270 | 0.065 | 32.000 | 5.400 | 14325 | 2795 | 5° |
| 8.00 | 3 | 270 | 0.080 | 42.000 | 7.200 | 10745 | 2580 | 5° |
| 10.00 | 3 | 315 | 0.095 | 53.000 | 9.000 | 10025 | 2860 | 5° |
| 12.00 | 3 | 315 | 0.110 | 63.000 | 10.800 | 8355 | 2755 | 5° |
| 16.00 | 3 | 360 | 0.130 | 84.000 | 14.400 | 7160 | 2795 | 5° |
| 20.00 | 3 | 360 | 0.145 | 105.000 | 18.000 | 5730 | 2490 | 5° |

| | | | | | | | | |
|-------|---|-----|-------|---------|--------|-------|------|----|
| 6.00 | 3 | 240 | 0.052 | 32.000 | 5.400 | 12730 | 1985 | 4° |
| 8.00 | 3 | 240 | 0.064 | 42.000 | 7.200 | 9550 | 1835 | 4° |
| 10.00 | 3 | 280 | 0.076 | 53.000 | 9.000 | 8915 | 2030 | 4° |
| 12.00 | 3 | 280 | 0.088 | 63.000 | 10.800 | 7425 | 1960 | 4° |
| 16.00 | 3 | 320 | 0.104 | 84.000 | 14.400 | 6365 | 1985 | 4° |
| 20.00 | 3 | 320 | 0.116 | 105.000 | 18.000 | 5095 | 1770 | 4° |

Application



Material

Wrought aluminium
Construction aluminium



Cast aluminium



Unalloyed copper



| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _r [mm/min] | Q [cm ³ /min] |
|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| 6.00 | 3 | 300 | 0.106 | 32.000 | 0.600 | 15915 | 5060 | 97.2 |
| 8.00 | 3 | 350 | 0.153 | 42.000 | 0.800 | 13925 | 6390 | 214.8 |
| 10.00 | 3 | 400 | 0.174 | 53.000 | 1.000 | 12730 | 6645 | 352.3 |
| 12.00 | 3 | 400 | 0.211 | 63.000 | 1.200 | 10610 | 6715 | 507.8 |
| 16.00 | 3 | 500 | 0.214 | 84.000 | 1.600 | 9945 | 6385 | 858.3 |
| 20.00 | 3 | 500 | 0.241 | 105.000 | 2.000 | 7960 | 5755 | 1208.2 |

| | | | | | | | | |
|-------|---|-----|-------|---------|-------|-------|------|--------|
| 6.00 | 3 | 270 | 0.106 | 32.000 | 0.600 | 14325 | 4555 | 87.5 |
| 8.00 | 3 | 315 | 0.153 | 42.000 | 0.800 | 12535 | 5755 | 193.3 |
| 10.00 | 3 | 360 | 0.174 | 53.000 | 1.000 | 11460 | 5980 | 317.0 |
| 12.00 | 3 | 360 | 0.211 | 63.000 | 1.200 | 9550 | 6045 | 457.0 |
| 16.00 | 3 | 450 | 0.214 | 84.000 | 1.600 | 8950 | 5745 | 772.5 |
| 20.00 | 3 | 450 | 0.241 | 105.000 | 2.000 | 7160 | 5180 | 1087.4 |

| | | | | | | | | |
|-------|---|-----|-------|---------|-------|-------|------|-------|
| 6.00 | 3 | 240 | 0.085 | 32.000 | 0.600 | 12730 | 3240 | 62.2 |
| 8.00 | 3 | 280 | 0.122 | 42.000 | 0.800 | 11140 | 4090 | 137.5 |
| 10.00 | 3 | 320 | 0.139 | 53.000 | 1.000 | 10185 | 4255 | 225.4 |
| 12.00 | 3 | 320 | 0.169 | 63.000 | 1.200 | 8490 | 4300 | 325.0 |
| 16.00 | 3 | 400 | 0.171 | 84.000 | 1.600 | 7960 | 4085 | 549.3 |
| 20.00 | 3 | 400 | 0.193 | 105.000 | 2.000 | 6365 | 3680 | 773.3 |



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