Corner radius end mills AX-RV2

Smooth-edged, version 3xd with neck

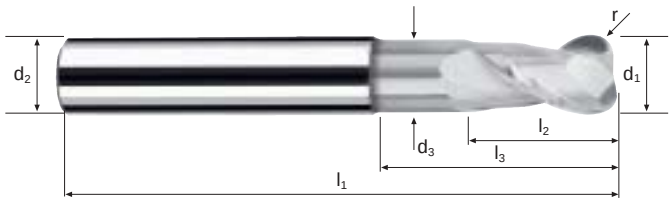
X-Generation

HM MG10

λ 40° γ 20°

G 2.5

Vario



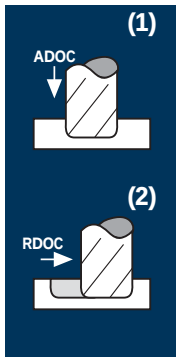
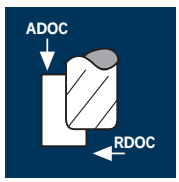
Roughing

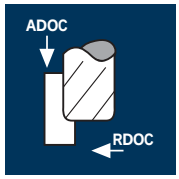
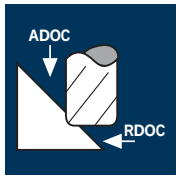
Finishing

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

Order-N°	**d1** e8	**d2** h6	**d3**	**l1**	**l2**	**l3**	**l3/d1**	**r** 0/+0.03	**α**	**fl**	
15573180	3	6	2.8	54	4	9	3.0	0.5	5.9°	2	●
15573220	4	6	3.7	54	5	12	3.0	0.5	3.7°	2	●
15573260	5	6	4.6	54	6	15	3.0	0.5	1.7°	2	●
15573302	6	6	5.5	54	7	18	3.0	1.0	0.0°	2	●
15573391	8	8	7.4	63	9	24	3.0	1.0	0.0°	2	●
15573453	10	10	9.2	72	11	30	3.0	1.5	0.0°	2	●
15573503	12	12	11.0	83	13	36	3.0	1.5	0.0°	2	●
15573611	16	16	15.0	97	18	48	3.0	2.0	0.0°	2	●
15573683	20	20	19.0	111	22	60	3.0	2.0	0.0°	2	●
15573774	25	25	24.0	132	27	75	3.0	2.5	0.0°	2	●

VIII

Application	Material	d1 [mm]	fl	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM = 5000 min^{-1} Feed [mm/min]	RPM = 10000 min^{-1} Feed [mm/min]	RPM = 15000 min^{-1} Feed [mm/min]	RPM = 20000 min^{-1} Feed [mm/min]
	Construction aluminium Aviation [AlMg1SiCu / 6061] [AlCu4MgSi / 2017] [AlCu2Mg1,5Ni / 2618] [AlZn5,5MgCu / 7175] [AlZn6CuMgZr / 7150] [AlCu4Mg1 / 2124] Wrought aluminium alloys [AlMgSi1 / 6082] Cast aluminium [G-AlSi11Mg]	3	2	0.050	2.0	3.0	500	1000	1500	2000
		4	2	0.065	3.0	4.0	650	1300	1950	2600
		6	2	0.100	4.0	6.0	1000	2000	3000	4000
		8	2	0.130	5.0	8.0	1300	2600	3900	5200
		10	2	0.165	5.5	10.0	1650	3300	4950	6600
		12	2	0.195	6.0	12.0	1950	3900	5850	7800
		16	2	0.210	6.5	16.0	2100	4200	6300	
		20	2	0.220	7.0	20.0	2200	4400		
		25	2	0.230	7.0	25.0	2300			
		3	2	0.050	2.0	2.4	500	1000	1500	2000
		4	2	0.065	3.0	3.2	650	1300	1950	2600
		6	2	0.100	4.0	4.8	1000	2000	3000	4000
		8	2	0.130	5.0	6.4	1300	2600	3900	5200
		10	2	0.165	5.5	8.0	1650	3300	4950	6600
		12	2	0.195	6.0	9.6	1950	3900	5850	7800
		16	2	0.210	6.5	12.8	2100	4200	6300	
		20	2	0.220	7.0	16.0	2200	4400		
		25	2	0.230	7.0	20.0	2300			
	Construction aluminium [AlZn5,5MgCu / 7175] Wrought aluminium alloys [AlMgSi1 / 6082] Cast aluminium [G-AlSi11Mg]	3	2	0.050	3.0	1.8	500	1000	1500	2000
		4	2	0.065	4.5	2.4	650	1300	1950	2600
		6	2	0.100	6.0	3.6	1000	2000	3000	4000
		8	2	0.130	7.5	4.8	1300	2600	3900	5200
		10	2	0.165	8.3	6.0	1650	3300	4950	6600
		12	2	0.195	9.0	7.2	1950	3900	5850	7800
		16	2	0.210	9.8	9.6	2100	4200	6300	
		20	2	0.220	10.5	12.0	2200	4400		
		25	2	0.230	10.5	15.0	2300			

Application	Material	d1 [mm]	fl	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM = 5000 min^{-1} Feed [mm/min]	RPM = 10000 min^{-1} Feed [mm/min]	RPM = 15000 min^{-1} Feed [mm/min]	RPM = 20000 min^{-1} Feed [mm/min]
	Construction aluminium [AlZn5,5MgCu / 7175] Wrought aluminium alloys [AlMgSi1 / 6082] Cast aluminium [G-AlSi11Mg]	3	2	0.015	2.5	0.10	150	300	450	600
		4	2	0.020	3.5	0.10	200	400	600	800
		6	2	0.030	5.0	0.20	300	600	900	1200
		8	2	0.040	7.0	0.25	400	800	1200	1600
		10	2	0.050	8.5	0.30	500	1000	1500	2000
		12	2	0.060	10.5	0.35	600	1200	1800	2400
		16	2	0.065	15.0	0.50	650	1300	1950	2600
		20	2	0.065	19.0	0.60	650	1300	1950	2600
		25	2	0.070	23.5	0.75	700	1400	2100	2800
							*ap_{lim} see page 604			
	Construction aluminium [AlZn5,5MgCu / 7175] Wrought aluminium alloys [AlMgSi1 / 6082] Cast aluminium [G-AlSi11Mg]	3	2	0.110	0.30	0.30	1100	2200	3300	4400
		4	2	0.145	0.35	0.35	1450	2900	4350	5800
		6	2	0.220	0.40	0.40	2200	4400	6600	8800
		8	2	0.285	0.45	0.45	2850	5700	8550	11400
		10	2	0.365	0.50	0.50	3650	7300	10950	14600
		12	2	0.430	0.60	0.60	4300	8600	12900	17200
		16	2	0.460	0.75	0.75	4600	9200	13800	18400
		20	2	0.485	1.00	1.00	4850	9700	14550	19400
		25	2	0.505	1.20	1.20	5050	10100	15150	20200