Corner radius end mills AX-RV2

Smooth-edged, version 4xd with neck

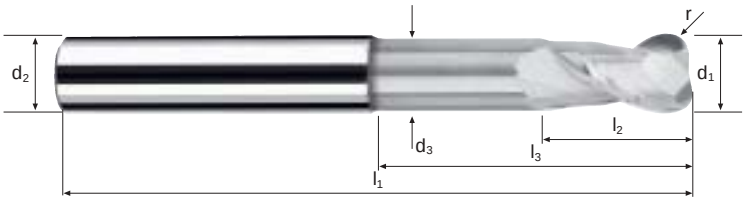
X-Generation

HM MG10

λ 40°
γ 20°

G 2.5

Vario



Roughing

Finishing

Al Aluminium > 99%

Al Aluminium Alloy

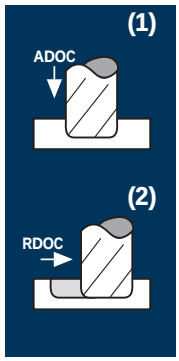
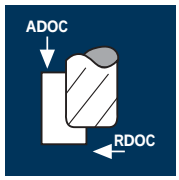
Al Aluminium Cast

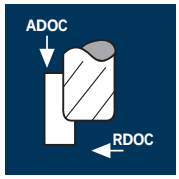
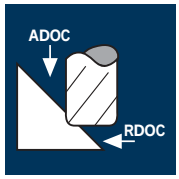
Cu Copper

Plastic Thermoplast

Order-N°	d1 e8	d2 h6	d3	l1	l2	l3	l3/d1	r 0/+0.03	fl	
15574453	10	10	9.2	84	11	40	4.0	1.5	2	●
15574503	12	12	11.0	97	13	48	4.0	1.5	2	●
15574611	16	16	15.0	115	18	64	4.0	2.0	2	●
15574683	20	20	19.0	130	22	80	4.0	2.0	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]	10	2	0.150	5.0	10.0	1500	3000	4500	6000
		12	2	0.180	5.5	12.0	1800	3600	5400	7200
		16	2	0.190	6.0	16.0	1900	3800	5700	
		20	2	0.205	6.5	20.0	2050	4100		
	Wrought aluminium alloys [AlMgSi1 / 6082]	10	2	0.150	5.0	6.0	1500	3000	4500	6000
		12	2	0.180	5.5	7.2	1800	3600	5400	7200
		16	2	0.190	6.0	9.6	1900	3800	5700	
		20	2	0.205	6.5	12.0	2050	4100		
	Cast aluminium [G-AlSi11Mg]									
	Construction aluminium [AlZn5,5MgCu / 7175] Wrought aluminium alloys [AlMgSi1 / 6082] Cast aluminium [G-AlSi11Mg]	10	2	0.150	7.5	6.0	1500	3000	4500	6000
		12	2	0.180	8.3	7.2	1800	3600	5400	7200
		16	2	0.190	9.0	9.6	1900	3800	5700	
		20	2	0.205	9.8	12.0	2050	4100		

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]	10	2	0.045	8.5	0.30	450	900	1350	1800
		12	2	0.055	10.5	0.35	550	1100	1650	2200
		16	2	0.055	15.0	0.50	550	1100	1650	2200
		20	2	0.060	19.0	0.60	600	1200	1800	2400
							*ap_{lim} see page 604			
	Construction aluminium [AlZn5,5MgCu / 7175] Wrought aluminium alloys [AlMgSi1 / 6082] Cast aluminium [G-AlSi11Mg]	10	2	0.330	0.50	0.50	3300	6600	9900	13200
		12	2	0.395	0.60	0.60	3950	7900	11850	15800
		16	2	0.420	0.75	0.75	4200	8400	12600	16800
		20	2	0.450	1.00	1.00	4500	9000	13500	18000