

Square end mills Multicut XA

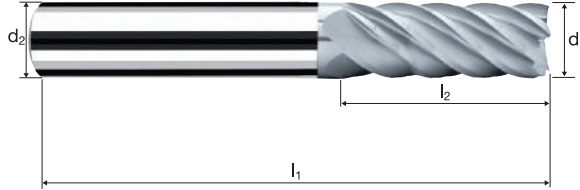
Finishing, normal version



**HM
MG10** λ 40°
 γ 20°

r G 2.5

Vario



new!

Roughing



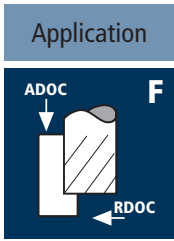
Finishing



			Al Aluminum > 99%	Al Aluminum Alloy	Al Aluminum Cast		Cu Copper	Plastic Thermoplast	
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Order-N°	d ₁ e8	d ₂ h6	l ₁	l ₂	r	fl	CELERO
C15589300	6	6	57	13	0.15	6	●
C15589391	8	8	63	19	0.15	6	●
C15589450	10	10	72	22	0.20	6	●
C15589501	12	12	83	26	0.20	6	●
C15589610	16	16	92	32	0.20	6	●
C15589682	20	20	104	40	0.20	6	●

VIII



Material

Wrought aluminum alloys Si < 6%

d1 [mm]	fl	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM = 10000 min ⁻¹ Feed [mm/min]	RPM = 15000 min ⁻¹ Feed [mm/min]	RPM = 20000 min ⁻¹ Feed [mm/min]	RPM = 30000 min ⁻¹ Feed [mm/min]
6	6	0.020	12	0.10	1200	1800	2400	3600
8	6	0.020	16	0.10	1200	1800	2400	3600
10	6	0.025	20	0.15	1500	2250	3000	4500
12	6	0.025	24	0.20	1500	2250	3000	4500
16	6	0.030	32	0.25	1800	2700	3600	
20	6	0.030	40	0.30	1800	2700	3600	

Unalloyed copper

6	6	0.020	12	0.10	1200	1800	2400	3600
8	6	0.020	16	0.10	1200	1800	2400	3600
10	6	0.025	20	0.15	1500	2250	3000	4500
12	6	0.025	24	0.20	1500	2250	3000	4500
16	6	0.030	32	0.25	1800	2700	3600	
20	6	0.030	40	0.30	1800	2700	3600	

Thermoplastics

6	6	0.020	12	0.10	1200	1800	2400	3600
8	6	0.020	16	0.10	1200	1800	2400	3600
10	6	0.025	20	0.15	1500	2250	3000	4500
12	6	0.025	24	0.20	1500	2250	3000	4500
16	6	0.030	32	0.25	1800	2700	3600	
20	6	0.030	40	0.30	1800	2700	3600	

Cast aluminum Si 6%-15%

6	6	0.020	12	0.10	1200	1800	2400	3600
8	6	0.020	16	0.10	1200	1800	2400	3600
10	6	0.025	20	0.15	1500	2250	3000	4500
12	6	0.025	24	0.20	1500	2250	3000	4500
16	6	0.030	32	0.25	1800	2700	3600	
20	6	0.030	40	0.30	1800	2700	3600	