

Square end mills Multicut XA

Finishing, medium length version

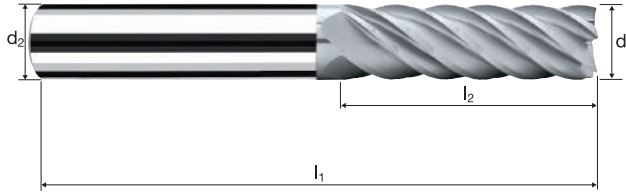


HM MG10 λ 40°
 γ 20°

r **G 2.5**

Vario

new!



Roughing

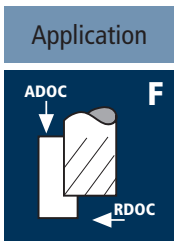
Finishing



		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
C15590300	6	6	63	18	0.15	6	●
C15590391	8	8	72	24	0.15	6	●
C15590450	10	10	84	30	0.20	6	●
C15590501	12	12	97	36	0.20	6	●
C15590610	16	16	108	48	0.20	6	●
C15590682	20	20	122	60	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	18	0.10	1200	1800	2400	3600
8	6	0.020	24	0.10	1200	1800	2400	3600
10	6	0.025	30	0.15	1500	2250	3000	4500
12	6	0.025	36	0.20	1500	2250	3000	4500
16	6	0.030	48	0.25	1800	2700	3600	
20	6	0.030	60	0.30	1800	2700	3600	

Unalloyed copper



6	6	0.020	18	0.10	1200	1800	2400	3600
8	6	0.020	24	0.10	1200	1800	2400	3600
10	6	0.025	30	0.15	1500	2250	3000	4500
12	6	0.025	36	0.20	1500	2250	3000	4500
16	6	0.030	48	0.25	1800	2700	3600	
20	6	0.030	60	0.30	1800	2700	3600	

Thermoplastics



6	6	0.020	18	0.10	1200	1800	2400	3600
8	6	0.020	24	0.10	1200	1800	2400	3600
10	6	0.025	30	0.15	1500	2250	3000	4500
12	6	0.025	36	0.20	1500	2250	3000	4500
16	6	0.030	48	0.25	1800	2700	3600	
20	6	0.030	60	0.30	1800	2700	3600	

Cast aluminum Si 6%-15%

6	6	0.020	18	0.10	1200	1800	2400	3600
8	6	0.020	24	0.10	1200	1800	2400	3600
10	6	0.025	30	0.15	1500	2250	3000	4500
12	6	0.025	36	0.20	1500	2250	3000	4500
16	6	0.030	48	0.25	1800	2700	3600	
20	6	0.030	60	0.30	1800	2700	3600	