Cylindrical end mills AX (AX-NV2)

Smooth-edged, normal version with short neck, with integral cooling channel

X-Generation

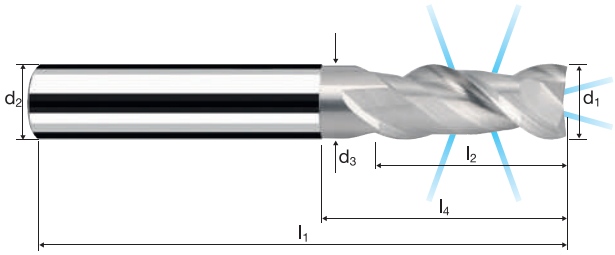
III

HM
MG10

λ 40°
γ 20°

90°

Vario



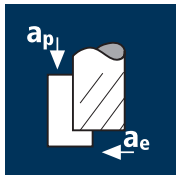
Roughing

Finishing

Rm < 850			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	

Example: **Order-N°.** Coating **C** Article-N°. **15525** ø-Code **300**

Ø Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	z	15625	CELERO C15625
									15525	C15525
300	6.00	6.00	5.50	57	13.00	19.34	20.00	2	●	●
391	8.00	8.00	7.40	63	19.00	25.29	26.00	2	●	●
450	10.00	10.00	9.20	72	22.00	30.20	31.00	2	●	●
501	12.00	12.00	11.00	83	26.00	36.13	37.00	2	●	●
610	16.00	16.00	15.00	92	32.00	42.13	43.00	2	●	●
682	20.00	20.00	19.00	104	38.00	52.13	53.00	2	●	●

Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
	Wrought aluminium Construction aluminium	6.00	2	650	0.065	9.000	3.300	34485	4485	133.1
		8.00	2	650	0.090	12.000	4.400	25865	4655	245.8
		10.00	2	650	0.110	15.000	5.500	20690	4550	375.5
		12.00	2	650	0.120	18.000	6.600	17240	4140	491.6
		16.00	2	650	0.135	24.000	8.800	12930	3490	737.4
		20.00	2	650	0.155	30.000	11.000	10345	3205	1058.3
	Unalloyed copper	6.00	2	500	0.050	9.000	3.300	26525	2655	78.8
		8.00	2	500	0.070	12.000	4.400	19895	2785	147.1
		10.00	2	500	0.090	15.000	5.500	15915	2865	236.3
		12.00	2	500	0.095	18.000	6.600	13265	2520	299.4
		16.00	2	500	0.105	24.000	8.800	9945	2090	441.2
		20.00	2	500	0.125	30.000	11.000	7960	1990	656.5
	Thermoplastics	6.00	2	792	0.065	9.000	3.300	42015	5460	162.2
		8.00	2	1056	0.090	12.000	4.400	42015	7565	399.3
		10.00	2	1200	0.110	15.000	5.500	38195	8405	693.3
		12.00	2	1200	0.120	18.000	6.600	31830	7640	907.6
		16.00	2	1200	0.135	24.000	8.800	23875	6445	1361.3
		20.00	2	1200	0.155	30.000	11.000	19100	5920	1953.8
	Cast aluminium	6.00	2	520	0.065	9.000	3.300	27585	3585	106.5
		8.00	2	520	0.090	12.000	4.400	20690	3725	196.6
		10.00	2	520	0.110	15.000	5.500	16550	3640	300.4
		12.00	2	520	0.120	18.000	6.600	13795	3310	393.3
		16.00	2	520	0.135	24.000	8.800	10345	2795	589.9
		20.00	2	520	0.155	30.000	11.000	8275	2565	846.6
	Wrought aluminium Construction aluminium	6.00	2	550	0.045	5.400	6.000	29180	2625	85.1
		8.00	2	550	0.060	7.200	8.000	21885	2625	151.3
		10.00	2	550	0.075	9.000	10.000	17505	2625	236.3
		12.00	2	550	0.085	10.800	12.000	14590	2480	321.4
		16.00	2	550	0.095	14.400	16.000	10940	2080	479.0
		20.00	2	550	0.110	18.000	20.000	8755	1925	693.3
	Unalloyed copper	6.00	2	450	0.040	5.400	6.000	23875	1910	61.9
		8.00	2	450	0.050	7.200	8.000	17905	1790	103.1
		10.00	2	450	0.060	9.000	10.000	14325	1720	154.7
		12.00	2	450	0.070	10.800	12.000	11935	1670	216.6
		16.00	2	450	0.075	14.400	16.000	8950	1345	309.4
		20.00	2	450	0.090	18.000	20.000	7160	1290	464.1
	Thermoplastics	6.00	2	792	0.045	5.400	6.000	42015	3780	122.5
		8.00	2	1000	0.060	7.200	8.000	39790	4775	275.0
		10.00	2	1000	0.075	9.000	10.000	31830	4775	429.7
		12.00	2	1000	0.085	10.800	12.000	26525	4510	584.4
		16.00	2	1000	0.095	14.400	16.000	19895	3780	870.9
		20.00	2	1000	0.110	18.000	20.000	15915	3500	1260.5
	Cast aluminium	6.00	2	440	0.045	5.400	6.000	23345	2100	68.1
		8.00	2	440	0.060	7.200	8.000	17505	2100	121.0
		10.00	2	440	0.075	9.000	10.000	14005	2100	189.1
		12.00	2	440	0.085	10.800	12.000	11670	1985	257.1
		16.00	2	440	0.095	14.400	16.000	8755	1665	383.2
		20.00	2	440	0.110	18.000	20.000	7005	1540	554.6