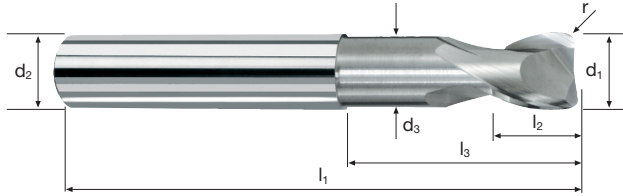


Corner radius end mills AluSpeed

Smooth-edged, normal version

HM	λ 30°
MG10	γ 15°



Roughing



Finishing

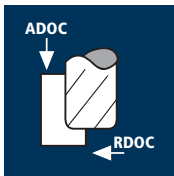


HRC < 24			Al Aluminum > 99%	Al Aluminum Alloy	Al Aluminum Cast		Cu Copper	Plastic Thermoplast	
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Order-N°	d1 e8	d2 h6	d3	l1	l2	l3	r 0/+0.03	α	fl	ReTool®	CELERO
											\$
C5275180	3	6	2.8	57	4	9	0.5	5.9°	2		63.00
C5275220	4	6	3.7	57	5	12	0.5	3.7°	2		63.00
C5275260	5	6	4.6	57	6	15	0.5	1.7°	2		63.00
C5275300	6	6	5.5	57	7	20	1.0	0.0°	2		63.00
C5275391	8	8	7.4	63	9	26	1.0	0.0°	2		78.00
C5275450	10	10	9.2	72	11	31	1.5	0.0°	2	●	107.00
C5275501	12	12	11.0	83	13	37	1.5	0.0°	2	●	132.00
C5275610	16	16	15.0	92	17	43	2.0	0.0°	2	●	206.00
C5275682	20	20	19.0	104	21	53	2.0	0.0°	2	●	301.00
C5275772	25	25	24.0	121	26	64	2.5	0.0°	2	●	570.00



VIII

Application





Material

Wrought aluminum alloys Si < 6%


d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM [min ⁻¹]	Feed [mm/min]	MRR [cm ³ /min]
3	2	450	0.045	2.4	1.4	47745	4295	14.5
4	2	450	0.060	3.2	1.8	35810	4295	24.5
5	2	450	0.075	4.0	2.3	28650	4300	39.5
6	2	450	0.095	4.8	2.7	23875	4535	59.0
8	2	450	0.130	6.4	3.6	17905	4655	107.5
10	2	450	0.160	8.0	4.5	14325	4585	165.0
12	2	450	0.175	9.6	5.4	11935	4175	216.5
16	2	450	0.195	12.8	7.2	8950	3490	321.5
20	2	450	0.230	16.0	9.0	7160	3295	474.5

Unalloyed copper

3	2	350	0.035	2.4	1.4	37135	2600	8.5
4	2	350	0.050	3.2	1.8	27850	2785	16.0
5	2	350	0.060	4.0	2.3	22280	2675	24.0
6	2	350	0.075	4.8	2.7	18570	2785	36.0
8	2	350	0.105	6.4	3.6	13925	2925	67.5
10	2	350	0.130	8.0	4.5	11140	2895	104.0
12	2	350	0.140	9.6	5.4	9285	2600	135.0
16	2	350	0.155	12.8	7.2	6965	2160	199.0
20	2	350	0.185	16.0	9.0	5570	2060	296.5

Thermoplastics



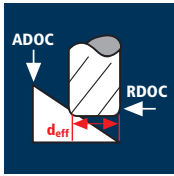
3	2	800	0.045	2.4	1.4	60000	5400	17.5
4	2	800	0.060	3.2	1.8	60000	7200	41.5
5	2	800	0.075	4.0	2.3	50930	7640	69.0
6	2	800	0.095	4.8	2.7	42440	8065	104.5
8	2	800	0.130	6.4	3.6	31830	8275	190.5
10	2	800	0.160	8.0	4.5	25465	8150	293.5
12	2	800	0.175	9.6	5.4	21220	7425	385.0
16	2	800	0.195	12.8	7.2	15915	6205	572.0
20	2	800	0.230	16.0	9.0	12730	5855	843.0

Cast aluminum Si 6% - 15%



3	2	300	0.030	2.4	1.4	31830	1910	6.0
4	2	300	0.040	3.2	1.8	23875	1910	11.0
5	2	300	0.055	4.0	2.3	19100	2100	19.0
6	2	300	0.065	4.8	2.7	15915	2070	27.0
8	2	300	0.090	6.4	3.6	11935	2150	49.5
10	2	300	0.110	8.0	4.5	9550	2100	75.5
12	2	300	0.125	9.6	5.4	7960	1990	103.0
16	2	300	0.135	12.8	7.2	5970	1610	148.5
20	2	300	0.160	16.0	9.0	4775	1530	220.5

Application



Material

Wrought aluminum alloys Si < 6%

d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	d _{eff} [mm]	RPM [min ⁻¹]	Feed [mm/min]	β [°]
3	2	600	0.055	0.25	0.25	2.97	60000	6600	45°
4	2	600	0.075	0.30	0.30	3.93	48600	7290	45°
5	2	600	0.090	0.35	0.35	4.89	39060	7030	45°
6	2	600	0.120	0.40	0.40	5.98	31940	7665	45°
8	2	600	0.160	0.45	0.45	7.96	23995	7680	45°
10	2	600	0.200	0.50	0.50	10.00	19100	7640	45°
12	2	600	0.220	0.60	0.60	11.97	15955	7020	45°
16	2	600	0.245	0.75	0.75	15.98	11950	5855	45°
20	2	600	0.285	1.00	1.00	19.86	9615	5480	45°

Unalloyed copper



3	2	450	0.045	0.25	0.25	2.97	48230	4340	45°
4	2	450	0.060	0.30	0.30	3.93	36450	4375	45°
5	2	450	0.070	0.35	0.35	4.89	29295	4100	45°
6	2	450	0.095	0.40	0.40	5.98	23955	4550	45°
8	2	450	0.130	0.45	0.45	7.96	17995	4680	45°
10	2	450	0.160	0.50	0.50	10.00	14325	4585	45°
12	2	450	0.175	0.60	0.60	11.97	11965	4190	45°
16	2	450	0.195	0.75	0.75	15.98	8965	3495	45°
20	2	450	0.230	1.00	1.00	19.86	7215	3320	45°

Thermoplastics



3	2	1000	0.055	0.25	0.25	2.97	60000	6600	45°
4	2	1000	0.075	0.30	0.30	3.93	60000	9000	45°
5	2	1000	0.090	0.35	0.35	4.89	60000	10800	45°
6	2	1000	0.120	0.40	0.40	5.98	53230	12775	45°
8	2	1000	0.160	0.45	0.45	7.96	39990	12795	45°
10	2	1000	0.200	0.50	0.50	10.00	31830	12730	45°
12	2	1000	0.220	0.60	0.60	11.97	26595	11700	45°
16	2	1000	0.245	0.75	0.75	15.98	19920	9760	45°
20	2	1000	0.285	1.00	1.00	19.86	16030	9135	45°

Cast aluminum Si 6% - 15%

3	2	400	0.040	0.25	0.25	2.97	42870	3430	45°
4	2	400	0.055	0.30	0.30	3.93	32400	3565	45°
5	2	400	0.065	0.35	0.35	4.89	26040	3385	45°
6	2	400	0.085	0.40	0.40	5.98	21290	3620	45°
8	2	400	0.110	0.45	0.45	7.96	15995	3520	45°
10	2	400	0.140	0.50	0.50	10.00	12735	3565	45°
12	2	400	0.155	0.60	0.60	11.97	10635	3295	45°
16	2	400	0.170	0.75	0.75	15.98	7970	2710	45°
20	2	400	0.200	1.00	1.00	19.86	6410	2565	45°