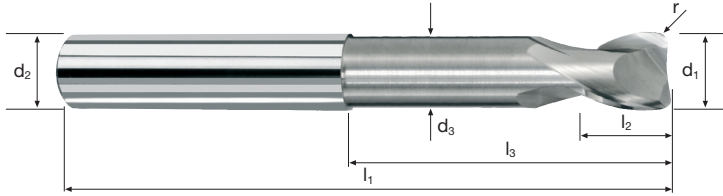


# Corner radius end mills AluSpeed

Smooth-edged, medium length version

<b>HM MG10</b>	$\lambda$ 30° $\gamma$ 15°



Roughing



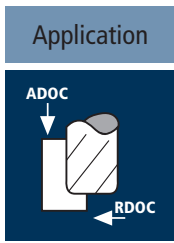
Finishing



<b>HRC</b> < 24			<b>Al</b> Aluminum > 99%	<b>Al</b> Aluminum Alloy	<b>Al</b> Aluminum Cast		<b>Cu</b> Copper	<b>Plastic</b> Thermoplast	
--------------------	--	--	--------------------------------	--------------------------------	-------------------------------	--	---------------------	-------------------------------	--

Order-N°	d1 e8	d2 h6	d3	l1	l2	l3	r 0/+0.03	fl	ReTool®	CELERO
										\$
C5277300	6	6	5.5	70	7	33	1.0	2		71.00
C5277391	8	8	7.4	80	9	43	1.0	2		88.00
C5277450	10	10	9.2	84	11	43	1.5	2	●	120.00
C5277501	12	12	11.0	97	13	51	1.5	2	●	148.00
C5277610	16	16	15.0	115	17	66	2.0	2	●	232.00
C5277682	20	20	19.0	130	21	79	2.0	2	●	339.00

VIII



Material

Wrought aluminum alloys Si < 6%

d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM [min <sup>-1</sup> ]	Feed [mm/min]	MRR [cm <sup>3</sup> /min]
6	2	400	0.095	3.6	1.5	21220	4030	22.0
8	2	400	0.130	4.8	2.0	15915	4140	39.5
10	2	400	0.160	6.0	2.5	12730	4075	61.0
12	2	400	0.175	7.2	3.0	10610	3715	80.0
16	2	400	0.195	9.6	4.0	7960	3105	119.0
20	2	400	0.230	12.0	5.0	6365	2930	176.0

Material

Unalloyed copper

6	2	300	0.075	3.6	1.5	15915	2385	13.0
8	2	300	0.105	4.8	2.0	11935	2505	24.0
10	2	300	0.130	6.0	2.5	9550	2485	37.5
12	2	300	0.140	7.2	3.0	7960	2230	48.0
16	2	300	0.155	9.6	4.0	5970	1850	71.0
20	2	300	0.185	12.0	5.0	4775	1765	106.0

Material

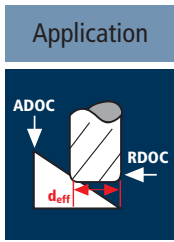
Thermoplastics

6	2	700	0.095	3.6	1.5	37135	7055	38.0
8	2	700	0.130	4.8	2.0	27850	7240	69.5
10	2	700	0.160	6.0	2.5	22280	7130	107.0
12	2	700	0.175	7.2	3.0	18570	6500	140.5
16	2	700	0.195	9.6	4.0	13925	5430	208.5
20	2	700	0.230	12.0	5.0	11140	5125	307.5

Material

Cast aluminum Si 6% - 15%

6	2	250	0.065	3.6	1.5	13265	1725	9.5
8	2	250	0.090	4.8	2.0	9945	1790	17.0
10	2	250	0.110	6.0	2.5	7960	1750	26.5
12	2	250	0.125	7.2	3.0	6630	1660	36.0
16	2	250	0.135	9.6	4.0	4975	1345	51.5
20	2	250	0.160	12.0	5.0	3980	1275	76.5



Material

Wrought aluminum alloys Si < 6%

d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	d <sub>eff</sub> [mm]	RPM [min <sup>-1</sup> ]	Feed [mm/min]	β [°]
6	2	500	0.110	0.35	0.35	5.99	26570	5845	45°
8	2	500	0.145	0.40	0.40	7.98	19945	5785	45°
10	2	500	0.180	0.45	0.45	10.00	15915	5730	45°
12	2	500	0.240	0.50	0.50	12.00	13265	6365	45°
16	2	500	0.320	0.60	0.60	16.00	9945	6365	45°
20	2	500	0.400	0.75	0.75	19.98	7965	6370	45°

Material

Unalloyed copper

6	2	400	0.090	0.35	0.35	5.99	21255	3825	45°
8	2	400	0.115	0.40	0.40	7.98	15955	3670	45°
10	2	400	0.145	0.45	0.45	10.00	12735	3695	45°
12	2	400	0.190	0.50	0.50	12.00	10610	4030	45°
16	2	400	0.255	0.60	0.60	16.00	7960	4060	45°
20	2	400	0.320	0.75	0.75	19.98	6375	4080	45°

Material

Thermoplastics

6	2	800	0.110	0.35	0.35	5.99	42515	9355	45°
8	2	800	0.145	0.40	0.40	7.98	31910	9255	45°
10	2	800	0.180	0.45	0.45	10.00	25465	9165	45°
12	2	800	0.240	0.50	0.50	12.00	21220	10185	45°
16	2	800	0.320	0.60	0.60	16.00	15915	10185	45°
20	2	800	0.400	0.75	0.75	19.98	12745	10195	45°

Material

Cast aluminum Si 6% - 15%

6	2	300	0.075	0.35	0.35	5.99	15945	2390	45°
8	2	300	0.100	0.40	0.40	7.98	11965	2395	45°
10	2	300	0.125	0.45	0.45	10.00	9550	2390	45°
12	2	300	0.170	0.50	0.50	12.00	7960	2705	45°
16	2	300	0.225	0.60	0.60	16.00	5970	2685	45°
20	2	300	0.280	0.75	0.75	19.98	4780	2675	45°