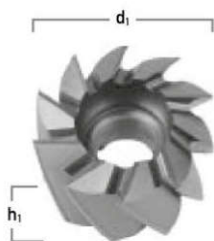




# AX 514

Uncoated	Alcrona Pro	Z 8-14	30°	HSS	Type N	DIN 1880
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## HSS Shell End Mill



d <sub>1</sub> mm	h <sub>1</sub> mm	d mm	Z	Uncoated	Coated	f <sub>r</sub> Roughing	f <sub>r</sub> Finishing
				Part No.	Part No.	mm/Z	mm/Z
40,0	32	16	8	AX514001	AX514001A	0,070	0,050
50,0	36	22	8	AX514002	AX514002A	0,075	0,055
63,0	40	27	10	AX514003	AX514003A	0,080	0,060
80,0	45	27	10	AX514004	AX514004A	0,095	0,075
100,0	50	32	10	AX514005	AX514005A	0,105	0,085
125,0	56	40	14	AX514006	AX514006A	0,120	0,100

d <sub>1</sub>	d
js16	H7

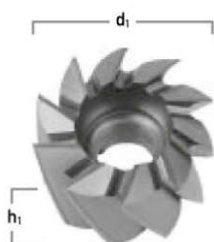


Peripheral milling  
 $a_e = 0,75xD$   
 $a_p = 0,5xD$

# AX 814

Uncoated	Alcrona Pro	Z 8-12	30°	HSS- Co5	Type N	DIN 1880
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## HSS-Co5 Shell End Mill



d <sub>1</sub> mm	h <sub>1</sub> mm	d mm	Z	Uncoated	Coated	f <sub>r</sub> Roughing	f <sub>r</sub> Finishing
				Part No.	Part No.	mm/Z	mm/Z
40,0	32	16	8	AX814001	AX814001A	0,070	0,050
50,0	36	22	8	AX814002	AX814002A	0,075	0,055
63,0	40	27	8	AX814003	AX814003A	0,080	0,060
80,0	45	27	10	AX814004	AX814004A	0,095	0,075
100,0	50	32	12	AX814005	AX814005A	0,105	0,085

d <sub>1</sub>	d
js16	H7



Peripheral milling  
 $a_e = 0,75xD$   
 $a_p = 0,5xD$

Material	Steel	Stainless	Cast
Tensile strength/ Hardness	< 850 N/mm <sup>2</sup>	< 750 N/mm <sup>2</sup>	< 800 N/mm <sup>2</sup>
V <sub>c</sub> (m/min) Finishing	40	25	30
V <sub>c</sub> (m/min) Roughing	25	15	20