



AX 518



HSS Shell End Mill



d ₁ mm	h ₁ mm	d mm	Z	Uncoated	Coated	f _r Roughing mm/Z	f _f Finishing mm/Z
				Part No.	Part No.		
40,0	32	16	6	AX518001	AX518001A	0,070	0,050
50,0	36	22	6	AX518002	AX518002A	0,075	0,055
63,0	40	27	8	AX518003	AX518003A	0,080	0,060
80,0	45	27	8	AX518004	AX518004A	0,095	0,075
100,0	50	32	10	AX518005	AX518005A	0,105	0,085
125,0	56	40	12	AX518006	AX518006A	0,120	0,100

d ₁	d
js16	H7



Peripheral milling
 $a_p = 0,75 \times d$
 $a_b = 0,5 \times d$

AX 818



HSS-Co5 Shell End Mill



d ₁ mm	h ₁ mm	d mm	Z	Uncoated	Coated	f _r Roughing mm/Z	f _f Finishing mm/Z
				Part No.	Part No.		
40,0	32	16	6	AX818001	AX818001A	0,070	0,050
50,0	36	22	6	AX818002	AX818002A	0,075	0,055
63,0	40	27	8	AX818003	AX818003A	0,080	0,060
80,0	45	27	8	AX818004	AX818004A	0,095	0,075
100,0	50	32	10	AX818005	AX818005A	0,105	0,085

d ₁	d
js16	H7



Peripheral milling
 $a_p = 0,75 \times d$
 $a_b = 0,5 \times d$

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