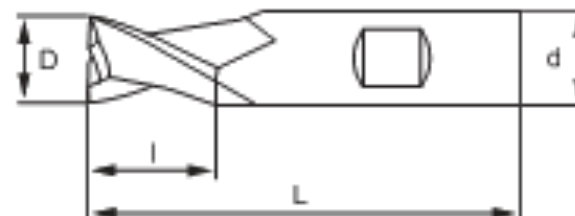


END MILLS Z2



ITEM: A5010 - A5015

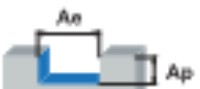
Material High speed steel Co8
Standard DIN 327B
Tolerance e8
Shank Weldon
Helix 30° right-hand
Surface treatment BRIGHT / WIND
Application Slotting



< 500	< 850	< 1200	< 600	< 850	Duplex	< 240	< 300	< 10% Si	> 10% Si	Brass Copper	Ti6Al4V	HTA	< 45	< 60	< 65
●	●	○	●	○				○	○						

DIN 327 B

	Tech. Code A5010			Tech. Code A5015		D mm	L mm	l mm	d mm	Z		
2T - 30°	...1,5	Bright		-	WIND	1,50	49	4	6	2	1	
	...2			...2		2,00						
	...2,5			...2,5		2,50		5				
	...3			...3		3,00						
	...3,5			-		3,50	51	7				
	...4			...4		4,00						
	-			...4,5		4,50						52
	...5			...5		5,00						
	...5,5			...5,5		5,50						
	...6			...6		6,00						
	-			...6,5		6,50	60	10	10			
	...7			...7		7,00						
	...7,5			...7,5		7,50		61				11
	...8			...8		8,00						
	...8,5			...8,5		8,50						
	...9			...9		9,00						
	...9,5			...9,5		9,50	63	13				12
	...10			...10		10,00						
	...10,5			...10,5		10,50						
	...11			...11		11,00	73	16				
	...11,5			...11,5		11,50						
	...12			...12		12,00						
	...12,5			...12,5		12,50						
	...13			...13		13,00	79	19	16			
	-			...13,5		13,50						
	...14			...14		14,00						
	...15			...15		15,00						
	...16			...16		16,00	88	22	20			
	...17			...17		17,00						
	...18			...18		18,00						
...19		-	19,00	102	26	25						
...20		...20	20,00									
...22		...22	22,00									
-		...25	25,00									
-		...28	28,00									
-		...30	30,00									

		Side Milling		Slotting	RANGE									
					A5010					A5015				
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 6	D/mm 8	D/mm 10	D/mm 12	D/mm 16	D/mm 20	D/mm 25
CARBON STEEL	< 500 N/mm²	1.5 x D	0.2 x D	0.5 x D	25	32	fz/mm	0.018	0.028	0.034	0.041	0.055	0.059	0.067
	< 850 N/mm²	1.5 x D	0.2 x D	0.5 x D	20	29	fz/mm	0.019	0.030	0.038	0.045	0.060	0.065	0.068
	< 1200 N/mm²	1.5 x D	0.2 x D	0.5 x D	17	22	fz/mm	0.017	0.023	0.036	0.043	0.057	0.057	0.063
STAINLESS STEEL	< 600 N/mm²	1.5 x D	0.2 x D	0.5 x D	10	14	fz/mm	0.020	0.027	0.033	0.041	0.056	0.056	0.061
	< 800 N/mm²	1.5 x D	0.2 x D	0.5 x D	8	12	fz/mm	0.017	0.023	0.036	0.043	0.057	0.057	0.063

Recommended "fz" values for side milling.
For slotting, adjust the cutting parameters. (ex: fz x 0.75)