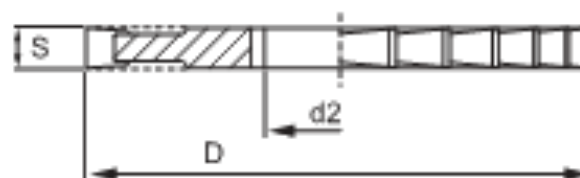


SLITTING CUTTERS

NdF	HSSE
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ITEM: A5455

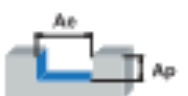
Material	High speed steel Co
Standard	Factory standard
Teeth	Alternate
Profile	Type N
Surface treatment	Bright
Application	For steel and cast iron slotting



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

FACTORY STANDARD

A5455	Tech. Code		D mm	S mm	d2 mm	Z			
	A5455631,6		63	1.6	22	32	1		
	A5455632			2				28	
	A5455632,5			2.5		36			
	A5455633			3					32
	A5455633,5			3.5					
	A5455802		2	27					44
	A5455802,5		2.5			40			
	A5455803		3					32	
	A5455803,5		3.5		44				
	A54551002		2			40			
	A54551002,5		2.5	32	44				
	A54551003		3			40			
	A54551003,5		3.5		32			44	
	A54551252		2						40
	A54551252,5		2.5			44			
	A54551253		3	40					
	A54551253,5		3.5					44	
	A54551254		4	40					

		Side Milling		Slotting	RANGE													
					A5455													
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 50 S 4-6	D/mm 50 S 8-10	D/mm 63 S 4-8	D/mm 63 S 10-14	D/mm 80 S 4-10	D/mm 80 S 12-18	D/mm 100 S 4-10	D/mm 100 S 14-16	D/mm 125 S 5-12	D/mm 125 S 14-20	D/mm 160 S 6-12
CARBON STEEL	< 500 N/mm²	-	-	0.1 x D	20	35	fz/mm	0.025	0.030	0.035	0.040	0.042	0.046	0.048	0.054	0.056	0.060	0.066
	< 850 N/mm²	-	-	0.1 x D	20	28	fz/mm	0.020	0.026	0.030	0.035	0.038	0.042	0.044	0.050	0.052	0.055	0.060
STAINLESS STEEL	< 600 N/mm²	-	-	0.1 x D	10	14	fz/mm	0.020	0.026	0.030	0.035	0.038	0.042	0.044	0.050	0.052	0.055	0.060
CAST IRON	< 240 HB	-	-	0.1 x D	16	22	fz/mm	0.025	0.030	0.035	0.040	0.042	0.046	0.048	0.054	0.056	0.060	0.066
	< 300 HB	-	-	0.1 x D	10	15	fz/mm	0.020	0.026	0.030	0.035	0.038	0.042	0.044	0.050	0.052	0.055	0.060

Recommended "fz" values for slotting.