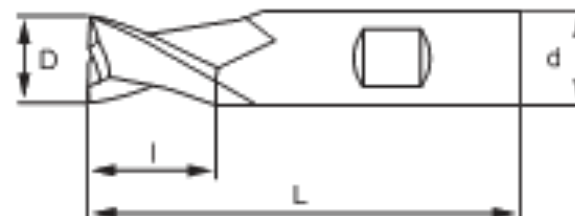


END MILLS Z2



ITEM: A5010 - A5015

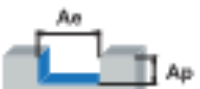
Material High speed steel Co8
Standard DIN 327B
Tolerance e8
Shank Weldon
Helix 30° right-hand
Surface treatment BRIGHT / WIND
Application Slotting



< 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		5					
	...2,5		...2,5	2,50							
	...3		...3	3,00		51	7				
	...3,5		-	3,50			52	8			
	...4		...4	4,00							
	-		...4,5	4,50		60		10			
	...5		...5	5,00			61	11			
	...5,5		...5,5	5,50							
	...6		...6	6,00							
	-		...6,5	6,50		70	13				
	...7		...7	7,00				73	12		
	...7,5		...7,5	7,50							
	...8		...8	8,00							
	...8,5		...8,5	8,50							
	...9		...9	9,00							
	...9,5		...9,5	9,50		79	19				
	...10		...10	10,00				88	22		
	...10,5		...10,5	10,50							
	...11		...11	11,00							
	...11,5		...11,5	11,50		102	26				
	...12		...12	12,00							
	...12,5		...12,5	12,50							
	...13		...13	13,00		30,00					
	-		...13,5	13,50							
	...14		...14	14,00							
	...15		...15	15,00							
	...16		...16	16,00							
	...17		...17	17,00							
	...18		...18	18,00							
	...19		-	19,00							
	...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)