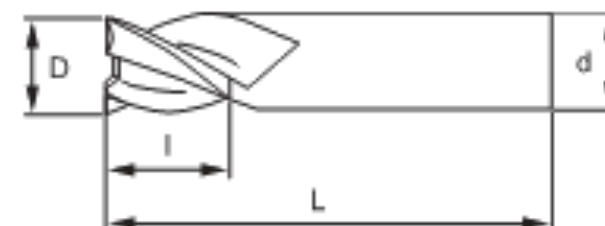


# LONG SERIES END MILLS CENTER CUTTING Z3



ITEM: A5120

Material High speed steel Co8  
Standard DIN 844  
Tolerance h7  
Shank Cylindrical / Weldon  
Helix 30° right-hand  
Surface treatment Bright  
Application Side milling



On request available with Weldon shank at a cost of € 2.  
Cylindrical shank (A5120....) Weldon shank (A5120...W)

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

| DIN 844  |            |  |         |         |         |         |   |                                                                                     |
|----------|------------|--|---------|---------|---------|---------|---|-------------------------------------------------------------------------------------|
| A5120    | Tech. Code |  | D<br>mm | L<br>mm | l<br>mm | d<br>mm | Z |  |
| 3T - 30° | A51203     |  | 3       | 56      | 12      | 6       | 3 | 1                                                                                   |
|          | A51204     |  | 4       | 63      | 19      |         |   |                                                                                     |
|          | A51205     |  | 5       | 68      | 24      |         |   |                                                                                     |
|          | A51206     |  | 6       |         |         |         |   |                                                                                     |
|          | A51208     |  | 8       | 88      | 38      | 10      |   |                                                                                     |
|          | A512010    |  | 10      | 95      | 45      |         |   |                                                                                     |
|          | A512012    |  | 12      | 110     | 53      | 12      |   |                                                                                     |
|          | A512014    |  | 14      |         |         |         |   |                                                                                     |
|          | A512016    |  | 16      | 123     | 63      | 16      |   |                                                                                     |
|          | A512018    |  | 18      |         |         |         |   |                                                                                     |
|          | A512020    |  | 20      | 141     | 75      | 20      |   |                                                                                     |

|                 |             | Side Milling |          | Slotting | RANGE                |                      |       |           |           |            |            |            |            |
|-----------------|-------------|--------------|----------|----------|----------------------|----------------------|-------|-----------|-----------|------------|------------|------------|------------|
|                 |             |              |          |          | A5120                |                      |       |           |           |            |            |            |            |
| Material        | Feature     | Ap           | Ae       | Ap       | Vc<br>m/min.<br>min. | Vc<br>m/min.<br>max. | mm    | D/mm<br>6 | D/mm<br>8 | D/mm<br>10 | D/mm<br>12 | D/mm<br>16 | D/mm<br>20 |
| CARBON STEEL    | < 500 N/mm² | 1.5 x D      | 0.15 x D | -        | 20                   | 35                   | fz/mm | 0.025     | 0.035     | 0.045      | 0.060      | 0.090      | 0.120      |
|                 | < 850 N/mm² | 1.5 x D      | 0.15 x D | -        | 20                   | 28                   | fz/mm | 0.022     | 0.030     | 0.040      | 0.056      | 0.078      | 0.100      |
| STAINLESS STEEL | < 600 N/mm² | 1.5 x D      | 0.15 x D | -        | 10                   | 14                   | fz/mm | 0.022     | 0.030     | 0.040      | 0.056      | 0.078      | 0.100      |
| CAST IRON       | < 240 HB    | 1.5 x D      | 0.15 x D | -        | 16                   | 22                   | fz/mm | 0.025     | 0.035     | 0.045      | 0.060      | 0.090      | 0.120      |

Recommended "fz" values for side milling.