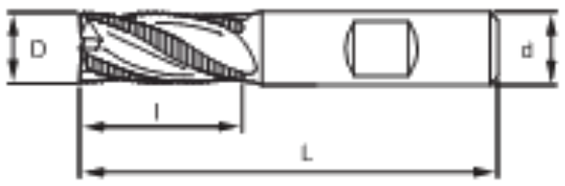
ROUGHING END MILLS MULTI-CUTTING

DIN 844 A | STD FINE | WIND | HB

ITEM: A5310 - A5315



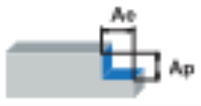
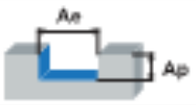
Material	High speed steel Co8
Standard	DIN 844 A
Tolerance	k12
Shank	Weldon
Helix	30° right-hand
Surface treatment	Bright / Wind
Application	Roughing

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

DIN 844A

	Tech. Code A5310			Tech. Code A5315			D mm	L mm	l mm	d mm	Z	
	...5			...5			5	57	13	6	4	1
	...6			...6			6					
	-			...6,5			6,5	66	16	10		
	...7			...7			7					
	...8			...8			8	69	19			
	-			...8,5			8,5					
	...9			...9			9					
	...10			...10			10	72	22			
	-			...10,5			10,5	79		12		
	...11			...11			11					
	...12			...12			12	83	26			
	...13			...13			13					
	...14			...14			14					
	...15			...15			15					
	...16			...16			16	92	32	16		
	-			...17			17	98		20		
	...18			...18			18	92		16		
	...20			...20			20	104	38	20		
	...22			...22			22					
	...24			-			24	121	45	25		
	...25			...25			25					
	-			...28			28				6	
	-			...32			32	133	53	32		

BRIGHT — WIND

	Side Milling		Slotting	RANGE									
				A5310					A5315				
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 x D	0.5 x D	1 x D	25	32	fz/mm	0.010	0.020	0.030	0.040	0.050	0.060	0.080
	< 850 N/mm²	1 x D	0.5 x D	1 x D	20	29	fz/mm	0.010	0.020	0.030	0.040	0.050	0.070	0.070
	< 1200 N/mm²	1 x D	0.5 x D	1 x D	17	22	fz/mm	0.010	0.020	0.020	0.030	0.040	0.050	0.070
STAINLESS STEEL	< 600 N/mm²	1 x D	0.5 x D	1 x D	10	14	fz/mm	0.010	0.010	0.020	0.030	0.040	0.050	0.060
	< 800 N/mm²	1 x D	0.5 x D	1 x D	8	12	fz/mm	0.010	0.010	0.020	0.030	0.040	0.050	0.060

Recommended "fz" values for slotting.
For side milling, adjust the cutting parameters. (ex: fz x 1.25)