

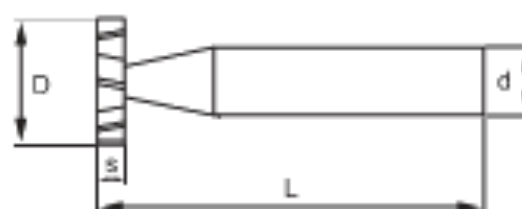
WOODRUFF KEYSEATS CUTTERS



ITEM: A5410

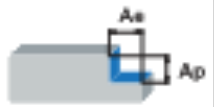
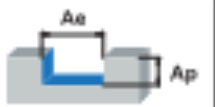
Material High speed steel Co
Standard DIN 850B
Shank Cylindrical / Weldon
Teeth Alternate
Surface treatment Bright
Application Woodruff keyseats

On request available with Weldon shank at a cost of € 2.
Cylindrical shank (A5410....) Weldon shank (A5410...W)



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

DIN 850 B											
A5410	Tech. Code		D mm	S mm	L mm	d mm	Z				
	A541010,52		10,50	2	50	6	8	1			
	A541010,52,5			2,5							
	A541010,53			3							
	A541013,52		13,50	2	56	10					
	A541013,53			3							
	A541013,54			4							
	A541016,53		16,50	3					63		
	A541016,54			4							
	A541016,55			5							
	A541019,53		19,50	3			71				
	A541019,54			4							
	A541019,55			5							
	A541019,56			6							
	A541022,54		22,50	4	12						
	A541022,55			5							
	A541022,56			6							
	A541022,58			8							
	A541025,56		25,50	6						71	
	A541028,56		28,50	6							
	A541028,58			8							
	A541028,510			10							
	A541032,56		32,50	6							12
	A541032,58			8							
	A541032,510			10							
	A541045,510		45,50	10							

		Side Milling		Slotting	RANGE								
					A5410								
Material	Feature	Ap	Ae	Ap	Vc m/min. min.	Vc m/min. max.	mm	D/mm 10	D/mm 16	D/mm 20	D/mm 25	D/mm 32	D/mm 40
CARBON STEEL	< 500 N/mm²	-	-	0.10 x D	20	35	fz/mm	0.035	0.040	0.055	0.064	0.072	0.080
	< 850 N/mm²	-	-	0.10 x D	20	28	fz/mm	0.032	0.036	0.050	0.058	0.066	0.072
STAINLESS STEEL	< 600 N/mm²	-	-	0.10 x D	10	14	fz/mm	0.028	0.032	0.044	0.052	0.058	0.064
CAST IRON	< 240 HB	-	-	0.10 x D	16	22	fz/mm	0.032	0.036	0.050	0.058	0.066	0.072
	< 300 HB	-	-	0.10 x D	10	15	fz/mm	0.028	0.032	0.044	0.052	0.058	0.064
SUPER ALLOY	Ti6Al4V	-	-	0.10 x D	7	10	fz/mm	0.022	0.036	0.036	0.042	0.046	0.056

Recommended "fz" values for slotting.