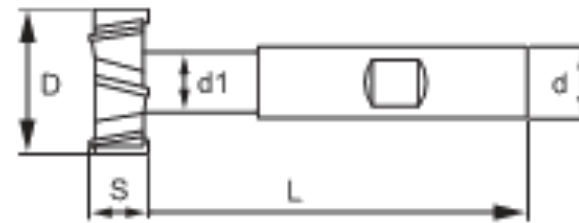


T-SLOT CUTTERS



ITEM: A5415

Material High speed steel Co
Standard DIN 850AB
Shank Weldon
Teeth Alternate
Surface treatment Bright
Application T-slots



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

DIN 850 AB

A5415	Tech. Code		D mm	S mm	d1 mm	L mm	d mm	Z	
	A541512,5		12.5	6	5	57	10	6	1
	A541516		16	8	7	62			
	A541518		18		8	70	12		
	A541521		21	9	10	74			
	A541525		25	11	12	82	16	8	
	A541528		28	12	13	75			
	A541532		32	14	15	90			
	A541536		36	16	17	95	25	10	
	A541540		40	18	19	108			

		Side Milling		Slotting	RANGE								
					A5415								
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	= S	1 x D	-	20	35	fz/mm	0,035	0,040	0,055	0,064	0,072	0,080
	< 850 N/mm²	= S	1 x D	-	20	28	fz/mm	0,032	0,036	0,050	0,058	0,066	0,072
STAINLESS STEEL	< 600 N/mm²	= S	1 x D	-	10	14	fz/mm	0,028	0,032	0,044	0,052	0,058	0,064
CAST IRON	< 240 HB	= S	1 x D	-	16	22	fz/mm	0,032	0,036	0,050	0,058	0,066	0,072
	< 300 HB	= S	1 x D	-	10	15	fz/mm	0,028	0,032	0,044	0,052	0,058	0,064
SUPERALLOY	Ti6Al4V	= S	1 x D	-	7	10	fz/mm	0,022	0,036	0,036	0,042	0,046	0,056

Recommended "fz" values for slotting.