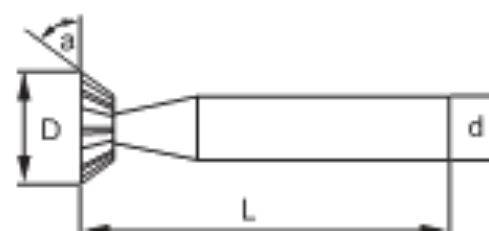


DOVETAIL CUTTERS



ITEM: A5420

Material High speed steel Co
Standard DIN 1833A
Shank Cylindrical
Teeth Front and side edges
Surface finish Bright
Application Side milling, chamfer and angular recesses on all materials.



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

DIN 1833 A								
A5420	Tech. Code		D mm	a °	L mm	d mm	Z	
	A54201645		16	45	60	12	10	1
	A54202045		20		63			
	A54202545		25		67			
	A54201660		16	60	60			
	A54202060		20		63			
	A54202560		25		67			

		Side Milling		Slotting	RANGE								
					A5420								
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
SUPER ALLOY	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.