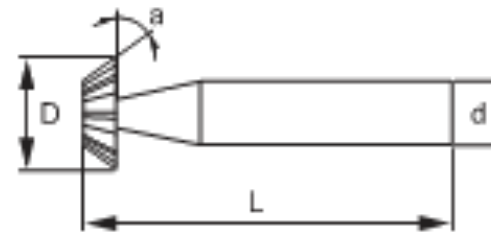


INVERTED DOVETAIL CUTTERS



ITEM: A5425

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

A5425	Tech. Code		D mm	a °	L mm	d mm	Z	
	A54251645		16	45	60	12	10	1
	A54252045		20		63			
	A54252545		25		67			
	A54251660		16	60	60			
	A54252060		20		63			
	A54252560		25		67			

		Side Milling		Slotting	RANGE								
					A5425								
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.