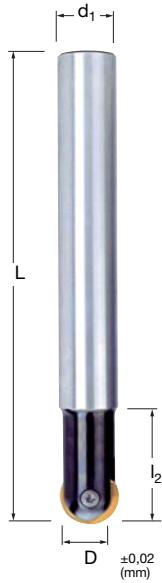
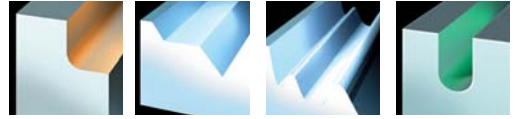


5500 V 25

Contour Milling Cutter



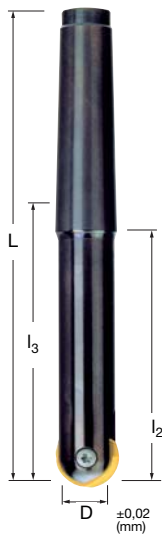
Cylindrical Shank

5500 V 25 Cylindrical Shank

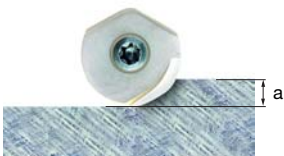
EDP#	Part Number	Dimensions (mm)							No. of Inserts	Spares			
		D	L	l ₂	l ₃	d ₁	MT	a		EDP#	EDP#	EDP#	
021674	5500V 25 CR	25	200	50	-	25	-	12,5	1	015253	55.677	015241	T20

5500 V 25 Morse Taper Shank

021675	5500V 25 MR	25	186	100	105	-	MT3	12,5	1	015253	55.677	015241	T20
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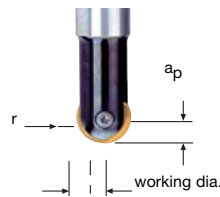
Morse Taper Shank



Depth of cut (a)

5500 V 25 Technical Advice

Milling Cutter Order Example: **5500V25CR**
 Milling Insert Order Example: **RG25 SP1032**
 For complete cutting conditions refer to page: **264**

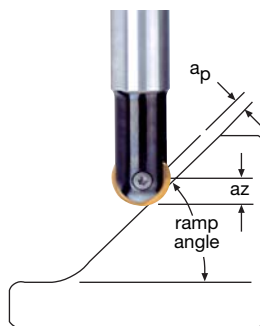


Working Diameter:

$$DW = 2 \times \sqrt{r^2 - (r - a_p)^2}$$

where: **DW** = Working Diameter
r = Cutter radius
a_p = Axial Depth of Cut

Ramp Milling Method

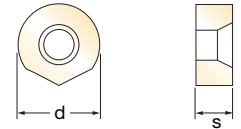


Ramp-up Data

Cutter Diameter 25,00 mm		Ramp Angle
ap (mm)	az (mm)	
9,3	12,1	15°
6,3	10,8	30°
3,7	8,8	45°
1,7	6,25	60°
0,4	3,2	75°
0,1	1,1	85°

Torque Limits 5.1 Nm

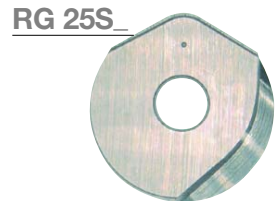
Inserts for 5500 V 25



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min.
024120	RG 25	SP1032	▼	▼▼	▼▼▼	25,0	-	4,0	12,5	0,02



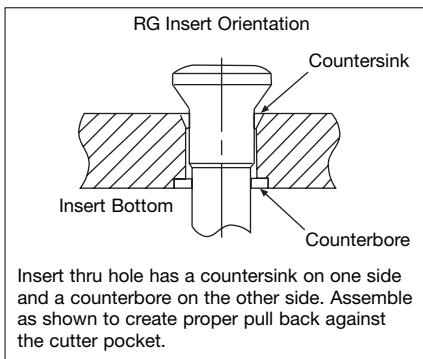
027799	RG 25S	SP1064				25,0	-	4,0	12,5	0,02
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Insert Interchangeability*

Metric		Inc h	
Diameter	Insert Number	Diameter	Insert Number
25 mm	RG 25	1.000 in.	RG1.00

*Insert interchangeability allows metric inserts to be used in inch cutters and vice-versa.



To find programmed feedrate:

$$f_z = h_m \times \sqrt{\frac{D}{a_p}} \times \sqrt{\frac{D_w}{a_e}}$$

where:

- f_z = Feed per tooth
- h_m = Average chip thickness
- D = Cutter diameter (outside)
- a_e = Radial Depth of Cut
- D_w = Working Diameter
- a_p = Axial Depth of Cut

Average chip thickness:

$$h_m = \frac{f_z}{\sqrt{\frac{D}{a_p}} \times \sqrt{\frac{D_w}{a_e}}}$$

RG_25 Recommended Cutting Conditions

Material	Speed	▼ Roughing	D.O.C.	Speed	▼▼ Semi-Finishing	D.O.C.	Speed	▼▼▼ Finishing	D.O.C.
	V _C (m/min)	Feed h _m (mm)		a _p (mm)	V _C (m/min)		Feed h _m (mm)	a _p (mm)	
◆ Unalloyed Steels	-	-	-	-	-	-	180 - 360	0,1 - 0,3	< 1,5
◆ Alloyed Steels	-	-	-	-	-	-	110 - 240	0,1 - 0,3	< 1,5
◆ Stainless Steels	-	-	-	-	-	-	140 - 240	0,1 - 0,2	< 1,5
◆ PH Stainless	-	-	-	-	-	-	120 - 190	0,1 - 0,2	< 1,5
◆ Cast Irons	-	-	-	-	-	-	100 - 160	0,1 - 0,2	< 1,5
◆ Aluminium & Alloys	-	-	-	-	-	-	400 - 1000	0,1 - 0,3	< 1,5
◆ High Temp. Alloys	-	-	-	-	-	-	45 - 60	0,1 - 0,2	< 1,5
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	50 - 100	0,03 - 0,06	< 0,5

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations								
	P ◆	Unalloyed Steels	M ◆	Stainless Steels	K ◆	Cast Irons	S ◆	High Temp. Alloys
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminium & Alloys	H ◆	Hard Materials