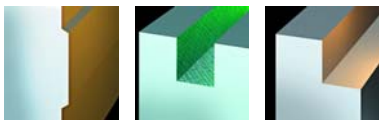
5210 VM 06 Long Edge Cutter



5210 VM 06 Weldon Shank

EDP #	Part Number	Dimensions (mm) D	L	l_1	l_2	d_1	a	No. of Inserts	Spares EDP#		EDP#	
021650	**5210VM 06 W020R26**	20	92	26	36	25	2	*a.* 5	015060	F2505T	018488	T7
								b. 1	015063	F3008T	013214	T9
021651	**5210VM 06 W025R32**	25	108	32	48	32	3	*a.* 11	015060	F2505T	018488	T7
								b. 1	015063	F3008T	013214	T9

5210 VM 06 Technical Advice

Milling Cutter Order Example: **5210VM06W020R26**
Milling Insert Order Example: **MPFW0602PPTR SFZ**
MPFW0803PPTR SFZ
For complete cutting conditions refer to page: **264**

Weldon Shank

Radial depth of cut, as a percentage of cutter diameter

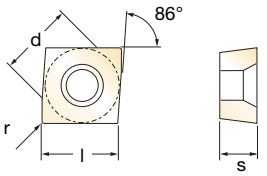
To find programmed feedrate:

$$h_m = f_z \times \sqrt{\frac{\text{Depth of Cut}}{\text{Cutter diameter}}}$$

where: f_z = Feed per tooth
h_m = Average chip thickness

Radial Depth of Cut	
% of Cutter Diameter	**Multiply feed rate by**
1%	6,5
2%	4,6
3%	3,8
4%	3,3
5%	2,9
6%	2,7
7%	2,5
8%	2,3
9%	2,2
10%	2,1
15%	1,7
20%	1,5
25%	1,3
30%	1,2
40%	1,0
50%	1,0
60%	1,0
70%	1,0
80%	1,0
90%	1,0
100%	1,0

Inserts for 5210 VM 06



MPFW 06_

EDP#	Part Number	Grade		Application & Material ▼ Roughing	▼▼ Semi-Finishing	▼▼▼ Finishing	Dimensions (mm) d	l	s	r	h_m min
017649	MPFW 06 02PPTR	GH1	a.				6,35	6,35	2,38	Facet	0,07
017647	MPFW 06 02PPTR	SF30	a.				6,35	6,35	2,38	Facet	0,07
014400	MPFW 06 02PPTR	SFZ	a.	◆◆			6,35	6,35	2,38	Facet	0,07
017648	MPFW 06 02PPTR	X44	a.	◆			6,35	6,35	2,38	Facet	0,07

MPFW 08_

017655	MPFW 08 03PPTR	GH1	b.				7,94	7,94	3,18	Facet	0,1
017653	MPFW 08 03PPTR	SF30	b.				7,94	7,94	3,18	Facet	0,1
014401	MPFW 08 03PPTR	SFZ	b.	◆◆			7,94	7,94	3,18	Facet	0,1
017654	MPFW 08 03PPTR	X44	b.	◆			7,94	7,94	3,18	Facet	0,1

* For ∅ 25, a_p max is 32 mm.
For ∅ 20, a_p max is 25 mm.

Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (m/min)	Feed/Rev. h_m (mm)	D.O.C.* a_p (mm)	▼▼ Semi-Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼▼ Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)
Unalloyed Steels	180 - 220	0,12 - 0,18	See l_1	-	-	-	-	-	-
Alloyed Steels	70 - 110	0,10 - 0,15	See l_1	-	-	-	-	-	-
Stainless Steels	-	-	-	-	-	-	-	-	-
PH Stainless	-	-	-	-	-	-	-	-	-
Cast Irons	140 - 280	0,10 - 0,15	See l_1	-	-	-	-	-	-
Aluminium & Alloys	-	-	-	-	-	-	-	-	-
High Temp. Alloys	-	-	-	-	-	-	-	-	-
Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

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

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