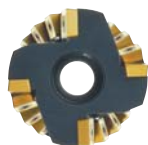
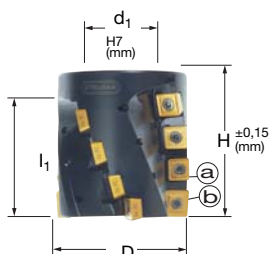


5210 VS 12 Long Edge Cutter



Shell Mill Fixation



DIN 69871 Shank



DIN 2080 Shank

5210 VS 12 Shell Mill Fixation													
EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares				
		D	L/H	I ₁	I ₂	I ₃	d ₁		EDP#	EDP#	EDP#		
021656	5210VS 12 -080R68	80	82	68	-	-	32	a.	14	015266	D5013T	015241	T20
								b.	2	015266	D5013T	015241	T20
021657	5210VS 12 -100R77	100	92	77	-	-	40	a.	27	015266	D5013T	015241	T20
								b.	2	015266	D5013T	015241	T20

5210 VS 12 DIN 69871 Shank													
EDP #	Part Number	D	L/H	I ₁	I ₂	I ₃	d ₁	No. of Inserts			Spares		
								a.	b.	c.	EDP#	EDP#	EDP#
021658	5210VS 12 G050R76	50	226	76	105	124,1	G50	a.	13	015266	D5013T	015241	T20
								b.	1	015266	D5013T	015241	T20

5210 VS 12 DIN 2080 Shank													
EDP #	Part Number	D	L/H	I ₁	I ₂	I ₃	d ₁	No. of Inserts			Spares		
								a.	b.	c.	EDP#	EDP#	EDP#
021659	5210VS 12 T050R76	50	247	76	105	120,2	T50	a.	13	015266	D5013T	015241	T20
								b.	1	015266	D5013T	015241	T20
021660	5210VS 12 T063R95	63	262	95	120	135,2	T50	a.	20	015266	D5013T	015241	T20
								b.	2	015266	D5013T	015241	T20



5210 VS 12 Technical Advice

Milling Cutter Order Example: **5210VS12-080R68**
 Milling Insert Order Example: **SOMT12M612SN-B PFZ**
SOMT15M612SN-B PFZ
 For complete cutting conditions refer to page: **264**

Radial depth of cut, as a percentage of cutter diameter

To find programmed feedrate:

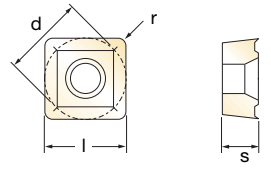
$$h_m = f_z \times \sqrt{\frac{\text{Depth of Cut}}{\text{Cutter diameter}}}$$

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 VS 12



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017329	SOMT 12 M612SN-B	MP91M a.				12,7	12,7	6,0	1,2	0,15
017733	SOMT 12 M612SN-B	GH1 a.				12,7	12,7	6,0	1,2	0,15
017734	SOMT 12 M612SN-B	PFZ a.	◆			12,7	12,7	6,0	1,2	0,15
017732	SOMT 12 M612SN-B	SF30 a.				12,7	12,7	6,0	1,2	0,15
017735	SOMT 12 M612SN-B	SFZ a.	◆			12,7	12,7	6,0	1,2	0,15
015191	SOMT 12 M612SN-B	X44 a.				12,7	12,7	6,0	1,2	0,15
015190	SOMT 12 M612SN-B	X500 a.	◆			12,7	12,7	6,0	1,2	0,15
017330	SOMT 15 M612SN-B	MP91M b.				15,88	15,88	6,0	1,2	0,15
017737	SOMT 15 M612SN-B	GH1 b.				15,88	15,88	6,0	1,2	0,15
017738	SOMT 15 M612SN-B	PFZ b.	◆			15,88	15,88	6,0	1,2	0,15
017736	SOMT 15 M612SN-B	SF30 b.				15,88	15,88	6,0	1,2	0,15
017739	SOMT 15 M612SN-B	SFZ b.	◆			15,88	15,88	6,0	1,2	0,15
015193	SOMT 15 M612SN-B	X44 b.				15,88	15,88	6,0	1,2	0,15
015192	SOMT 15 M612SN-B	X500 b.	◆			15,88	15,88	6,0	1,2	0,15

SOMT 12_



SOMT 15_



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/Rev. h _m (mm)		a _p (mm)	V _C (m/min)		Feed h _m (mm)	a _p (mm)	
◆ Unalloyed Steels	180 - 220	0,30 - 0,50	See I ₁	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,25 - 0,45	See I ₁	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,25 - 0,45	See I 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