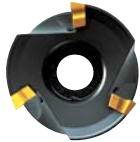
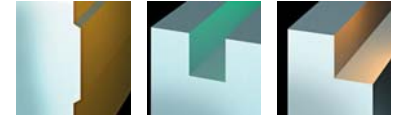
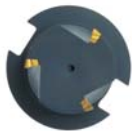


5315 VA 16 Long Edge Cutter



Shell Mill Fixation





BT Fixation



DIN 69871 Fixation

5315 VA 16 Shell Mill Fixation

EDP #	Part Number	Dimensions (mm)							No. of Inserts	Spares			
		D	L/H	l ₁	l ₂	l ₃	d ₁	EDP#			EDP#		
025670	5315VA 16 -A050Z3R31	50	55	31	-	-	27	6	015262	D4010T	015240	T15	
025671	5315VA 16 -A050Z4R31	50	55	31	-	-	27	8	015262	D4010T	015240	T15	
025674	5315VA 16 -A063Z4R31	63	55	31	-	-	27	8	015262	D4010T	015240	T15	
025675	5315VA 16 -A063Z5R31	63	55	31	-	-	27	10	015262	D4010T	015240	T15	
025678	5315VA 16 -A080Z4R31	80	55	31	-	-	32	8	015262	D4010T	015240	T15	
025679	5315VA 16 -A080Z5R31	80	55	31	-	-	32	10	015262	D4010T	015240	T15	

5315 VA 16 BT Fixation

025668	5315VA 16 BA50/050R61	50	225,8	61	124	75	-	12	015262	D4010T	015240	T15
025672	5315VA 16 BA50/063R61	63	225,8	61	124	75	-	12	015262	D4010T	015240	T15
025676	5315VA 16 BA50/080R91	80	259,8	91	158	115	-	24	015262	D4010T	015240	T15

5315 VA 16 DIN 69871 Fixation

025669	5315VA 16 GA50/050R61	50	206,7	61	105	75	-	12	015262	D4010T	015240	T15
025673	5315VA 16 GA50/063R61	63	206,7	61	105	75	-	12	015262	D4010T	015240	T15
025677	5315VA 16 GA50/080R91	80	240,7	91	138	115	-	24	015262	D4010T	015240	T15

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

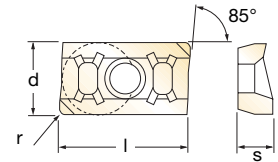
% of Cutter Diameter	Multiply feed rate by
1%	6,5
2%	4,6
3%	3,8
4%	3,3
5%	2,9
6%	2,7
7%	2,5
8%	2,3
9%	2,2
10%	2,1
15%	1,7
20%	1,5
25%	1,3
30%	1,2
40%	1,0
50%	1,0
60%	1,0
70%	1,0
80%	1,0
90%	1,0
100%	1,0

AP_16 Recommended Cutting Conditions

Material	▼ Roughing			▼ Semi-Finishing			▼ Finishing		
	Speed V _C (m/min)	Feed/Flute h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)
◆ Unalloyed Steels	180 - 220	0,20 - 0,38	See l ₁	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,15 - 0,30	See l ₁	-	-	-	-	-	-
◆ Stainless Steels	120 - 140	0,12 - 0,25	See l ₁	-	-	-	-	-	-
◆ PH Stainless	55 - 70	0,10 - 0,18	See l ₁	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,15 - 0,30	See l ₁	-	-	-	-	-	-
◆ Aluminium & Alloys	275 - 450	0,05 - 0,12	See l ₁	-	-	-	-	-	-
◆ High Temp. Alloys	25 - 40	0,10 - 0,18	See l ₁	-	-	-	-	-	-
◆ Hard Steels (52-56 HRC)	50 - 85	0,05 - 0,10	See l ₁	-	-	-	-	-	-

h_m = average chip thickness

Inserts for 5315 VA 16



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017621	APEX 16 04PDER-701	PFZ				9,52	16,66	4,76	Facet	0,02
017623	APEX 16 04PDR-701	SFZ				9,52	16,66	4,76	Facet	0,02
014066	APEX 16 04PDR-701	GH1	◆			9,52	16,66	4,76	Facet	0,02
017291	APFW 16 04PDER	MP91M				9,52	16,66	4,76	Facet	0,04
017627	APFW 16 04PDTR	X44				9,52	16,66	4,76	Facet	0,1
017628	APFW 16 04PDTR	GH1				9,52	16,66	4,76	Facet	0,1
018030	APFW 16 04PDTR	CN35				9,52	16,66	4,76	Facet	0,1
017626	APFW 16 04PDTR	SF30				9,52	16,66	4,76	Facet	0,1
017629	APFW 16 04PDTR	SFZ	◆			9,52	16,66	4,76	Facet	0,1
017633	APHT 16 04PDER	SFZ				9,52	16,66	4,76	Facet	0,05
015154	APHT 16 04PDR	GH1				9,52	16,66	4,76	Facet	0,02
017293	APHT 16 04PDTR-42	MP91M				9,52	16,66	4,76	Facet	0,1
017634	APHT 16 04PDTR-42	PFZ				9,52	16,66	4,76	Facet	0,1
015155	APHT 16 04PDTR-42	X500				9,52	16,66	4,76	Facet	0,1
027718	APHT 16 04PDTR-42	SP6564				9,52	16,66	4,76	Facet	0,1
017294	APKT 16 04PDER-43	MP91M	◆			9,52	16,66	4,76	Facet	0,08
014067	APKT 16 04PDER-43	PFZ				9,52	16,66	4,76	Facet	0,08
015156	APKT 16 04PDER-43	X500				9,52	16,66	4,76	Facet	0,08
027720	APKT 16 04PDER-43	SP6564				9,52	16,66	4,76	Facet	0,08
023115	APKT 16 04PDER-45	X500	◆◆			9,52	16,66	4,76	Facet	0,06
023114	APKT 16 04PDER-45	MP91M	◆◆			9,52	16,66	4,76	Facet	0,06
027721	APKT 16 04PDER-45	SP6564	◆◆			9,52	16,66	4,76	Facet	0,06
023102	APET 16 0402TR-42	PFZ				9,52	16,66	4,76	0,2	0,1
023103	APET 16 0408TR-42	PFZ				9,52	16,66	4,76	0,8	0,1
023104	APET 16 0410TR-42	PFZ				9,52	16,66	4,76	1,0	0,1
023105	APET 16 0415TR-42	PFZ				9,52	16,66	4,76	1,5	0,1
023106	APET 16 0420TR-42	PFZ				9,52	16,66	4,76	2,0	0,1
017618	APET 16 0425TR-42	MP91M				9,52	16,66	4,76	2,5	0,1
017619	APET 16 0425TR-42	X500				9,52	16,66	4,76	2,5	0,1
011488	APKT 16 0408E-2C	MP91M				9,52	16,66	4,76	0,8	0,10
010796	APKT 16 0408E-2C	PFZ				9,52	16,66	4,76	0,8	0,10
012468	APKT 16 0408E-2C	SF30				9,52	16,66	4,76	0,8	0,10
017228	APMT 16 0412E-2C	MP91M				9,52	16,66	4,76	1,2	0,1
013944	APMT 16 0416E-2C	MP91M				9,52	16,66	4,76	1,6	0,1
013945	APMT 16 0424E-2C	MP91M				9,52	16,66	4,76	2,4	0,1



Note: For this style of cutter, 2,5 mm corner rad max.



5315 VA 16 Technical Advice

Milling Cutter Order Example: 5315VA16-A063Z5R31
Milling Insert Order Example: APFW1604PDER MP91M
For complete cutting conditions refer to page: 264

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