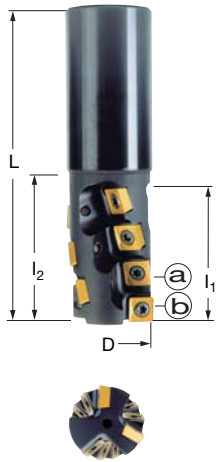
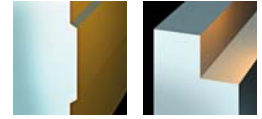
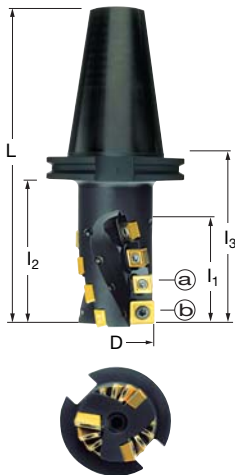


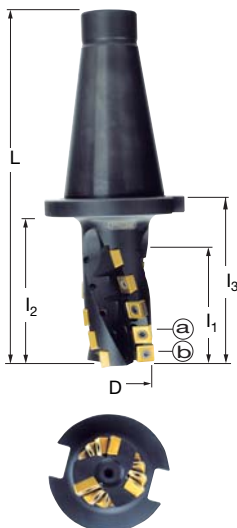
5210 VS 09 Long Edge Cutter



Weldon Shank



DIN 69871 Shank



DIN 2080 Shank

5210 VS 09 Weldon Shank

EDP #	Part Number	Dimensions (mm)							No. of Inserts	Spares			
		D	L	l ₁	l ₂	l ₃	d ₁	EDP#		EDP#	EDP#		
015235	5210VS 09 WA032R50	32	119	50	57	-	32	a.	11	015262	D4010T	015240	T15

5210 VS 09 DIN 69871 Shank

021652	5210VS 09 G032R45	32	144	45	57	76,1	G40	a.	11	015262	D4010T	015240	T15
021653	5210VS 09 G040R49	40	162	49	75	94,1	G40	b.	11	015262	D4010T	015240	T15
								c.	1	015265	D5010T	015241	T20

5210 VS 09 DIN 2080 Shank

021654	5210VS 09 T032R60	32	190	60	72	96,6	T40	a.	12	015262	D4010T	015240	T15
021655	5210VS 09 T040R49	40	180	49	75	94,1	T40	b.	11	015262	D4010T	015240	T15
								c.	1	015265	D5010T	015241	T20



5210 VS 09 Technical Advice

Milling Cutter Order Example: **5210VS09G032R45**
 Milling Insert Order Example: **SCMT09 T308T SFZ**

For complete cutting conditions refer to page: **264**

Radial depth of cut,
as a percentage of
cutter diameter

To find programmed feedrate:

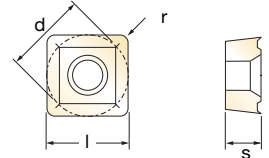
$$h_m = f_z \times \sqrt{\frac{\text{Depth of Cut}}{\text{Cutter diameter}}}$$

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

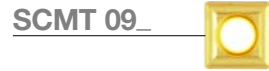
Radial Depth of Cut

% 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 09



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017703	SCMT 09 T308E	SF30	a.			9,52	9,52	3,97	0,8	0,15
018188	SCMT 09 T308E	SFZ	a.			9,52	9,52	3,97	0,8	0,15
024062	SCMT 09 T308E	X44	a.			9,52	9,52	3,97	0,8	0,15
015225	SCMT 09 T308T	PFZ	a.	◆		9,52	9,52	3,97	0,8	0,15
017704	SCMT 09 T308T	SF30	a.			9,52	9,52	3,97	0,8	0,15
017705	SCMT 09 T308T	SFZ	a.	◆		9,52	9,52	3,97	0,8	0,15
015224	SCMT 09 T308T	X44	a.	◆		9,52	9,52	3,97	0,8	0,15
017700	SCMT 09 M512SN-P	SF30	b.			9,52	9,52	5,0	1,2	0,15
017702	SCMT 09 M512SN-P	SFZ	b.	◆		9,52	9,52	5,0	1,2	0,15
017430	SCMT 09 M512SN-P	X44	b.	◆		9,52	9,52	5,0	1,2	0,15
017701	SCMT 09 M512SN-P	X500	b.	◆		9,52	9,52	5,0	1,2	0,15
023343	SCMT 09 M512SN-P	PFZ	b.	◆		9,52	9,52	5,0	1,2	0,15
024107	SCMT 09 T308EN-41	PFZ	a.			9,52	9,52	3,97	0,8	0,04
015147	SCMT 09 T308EN-41	X500	a.			9,52	9,52	3,97	0,8	0,04
027731	SCMT 09 T308EN-41	SP6564	a.			9,52	9,52	3,97	0,8	0,04
015227	SCMT 12 M512T	PFZ	c.	◆		12,7	12,7	5,0	1,2	0,15
017708	SCMT 12 M512T	SF30	c.			12,7	12,7	5,0	1,2	0,15
017710	SCMT 12 M512T	SFZ	c.	◆		12,7	12,7	5,0	1,2	0,15
015228	SCMT 12 M512T	X44	c.	◆		12,7	12,7	5,0	1,2	0,15
024129	SCMT 12 M512T	X500	c.			12,7	12,7	5,0	1,2	0,12
024108	SCMT 12 M512EN-41	PFZ	c.			12,7	12,7	5,0	1,2	0,05
015226	SCMT 12 M512EN-41	X500	c.			12,7	12,7	5,0	1,2	0,05
027732	SCMT 12 M512EN-41	SP6564	c.			12,7	12,7	5,0	1,2	0,05



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	0,25 - 0,40	See I ₁	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,20 - 0,35	See I ₁	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,20 - 0,35	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
◆	P	◆ Alloyed Steels	◆	M	◆ PH Stainless
◆			◆	K	◆ Cast Irons
◆			◆	N	◆ Aluminium & Alloys
◆			◆	S	◆ High Temp. Alloys
◆			◆	H	◆ Hard Materials