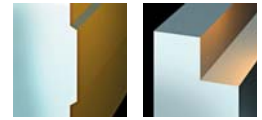




5210 VS 09 Long Edge Cutter



5210 VS 09 Weldon Shank

EDP #	Part Number	Dimensions (inch)					No. of Inserts	Spares			
		D	L	l ₂	l ₃	d ₁		EDP# 	EDP# 	EDP#	
015405	C5210VS09WA1.25R2.00	1.25	4.53	2.00	2.24	1.25	11	015262	D4010T	015240	T15



5210 VS 09 Technical Advice

Milling Cutter Order Example: **C5210VS09WA1.25R2.00**

Milling Insert Order Example: **SCMT09T308T SFZ**

For complete cutting conditions refer to page: **208**



Weldon Shank

Radial depth of cut, as a percentage of cutter diameter

To find programmed feedrate:

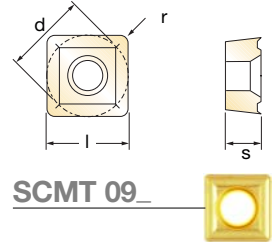
$$h_m = f_z \times \sqrt{\frac{\text{Depth of Cut}}{\text{Cutter diameter}}}$$

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 VS 09



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
017703	SCMT09T308E	SF30				0.375	0.375	0.156	0.031	0.0059
018188	SCMT09T308E	SFZ				0.375	0.375	0.156	0.031	0.0059
024062	SCMT09T308E	X44				0.375	0.375	0.156	0.031	0.0059
015225	SCMT09T308T	PFZ	◆			0.375	0.375	0.156	0.031	0.0059
017704	SCMT09T308T	SF30				0.375	0.375	0.156	0.031	0.0059
017705	SCMT09T308T	SFZ	◆			0.375	0.375	0.156	0.031	0.0059
015224	SCMT09T308T	X44	◆			0.375	0.375	0.156	0.031	0.0059

Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V_C (feet/min)	Feed/Rev. h_m (inch)	D.O.C. a_p (inch)	Speed V_C (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	Speed V_C (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)
◆ Unalloyed Steels	600 - 720	0.010 - 0.016	See l_1	-	-	-	-	-	-
◆ Alloyed Steels	230 - 360	0.008 - 0.014	See l_1	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	460 - 910	0.008 - 0.014	See l_1	-	-	-	-	-	-
◆ Aluminum & 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
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys
					S ◆	High Temp. Alloys
					H ◆	Hard Materials