

general engineering

5315VA12

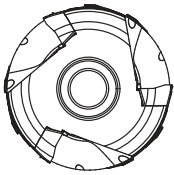
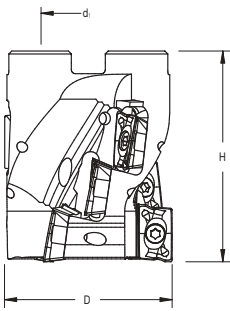


PERFORMANCE FEATURES

- Long edge milling cutter for profiling, slotting and face milling.
- Full effective flutes allowing higher feed rates.
- 3 geometries and 5 grades for increased productivity.
- PVD, CVD and uncoated grades for all applications.
- Through tool coolant for optimum swarf evacuation.

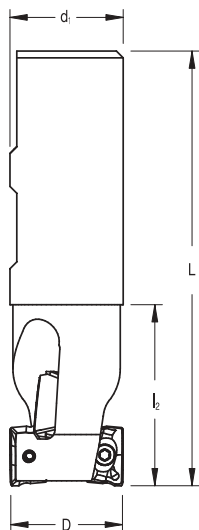
STELLRAM®

5315VA12 Milling Cutter



Shell Mill Fixation

5315VA12 Shell Mill Fixation												
EDP #	Part Number	Dimensions mm							Spares			
		D	L/H	l ₁ Profiling	l ₁ Slotting	l ₂	d ₁	No. of inserts	EDP #	EDP #	T8	
029110	5315VA12-A040R34	40	50	34	20	-	16	9	027860	F3007T	022157	T8



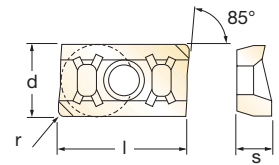
Weldon Shank

5315VA12 Weldon Shank												
EDP #	Part Number	D	L/H	l ₁ Profiling	l ₁ Slotting	l ₂	d ₁	No. of inserts	EDP #	EDP #	T8	
029106	5315VA12WA025R23	25	96	23	15	40	25	4	027860	F3007T	022157	T8
029107	5315VA12WA025R35	25	106	35	7	50	25	6	027860	F3007T	022157	T8
029108	5315VA12WA032R35	32	110	35	20	50	32	9	027860	F3007T	022157	T8
029109	5315VA12WA040R45	40	130	45	20	60	40	12	027860	F3007T	022157	T8

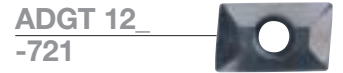
5315VA12 Technical Advice

Milling Cutter Order Example: **5315VA12-A040R34**
 Milling Insert Order Example: **ADKT12T3PDER-45**

Inserts for 5315VA12



EDP #	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
027914	ADKT12T3PDER-45	SP6564				7,87	12,70	4,76	Facet	0,05
027913	ADKT12T3PDER-45	X500				7,87	12,70	4,76	Facet	0,05
027915	ADKT12T3PDER-45	MP91M	◆			7,87	12,70	4,76	Facet	0,05
027916	ADKT12T3PDER-45	SC3025	◆			7,87	12,70	4,76	Facet	0,05



029098	ADGT12T3PDFR-721	GH1	◆			7,96	12,90	4,40	Facet	0,05
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029326	ADHT12T3PDER-46	SP6564	◆			8,00	12,90	4,40	Facet	0,05
029327	ADHT12T3PDER-46	X500	◆◆			8,00	12,90	4,40	Facet	0,05
029328	ADHT12T308R-46	SP6564	◆			8,00	12,90	4,40	0,8	0,05
029309	ADHT12T308R-46	X500	◆◆			8,00	12,90	4,40	0,8	0,05

Please note that for the 5315 range, only a maximum 0,8mm radius is allowed.

Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed f _z (mm/tooth)	D.O.C a _p (mm)	Speed V _C (m/min)	Feed f _z (mm/tooth)	D.O.C a _p (mm)	Speed V _C (m/min)	Feed f _z (mm/tooth)	D.O.C a _p (mm)
◆ Unalloyed Steels	120 - 305	0,06 - 0,12	-	-	-	-	-	-	-
◆ Alloyed Steels	75 - 175	0,06 - 0,10	-	-	-	-	-	-	-
◆ Stainless Steels	115 - 160	0,06 - 0,10	-	-	-	-	-	-	-
◆ PH Stainless	95 - 150	0,06 - 0,10	-	-	-	-	-	-	-
◆ Cast Irons	115 - 400	0,06 - 0,13	-	-	-	-	-	-	-
◆ Aluminium & Alloys	200 - 800	0,04 - 0,20	-	-	-	-	-	-	-
◆ High Temp. Alloys	25 - 40	0,04 - 0,10	-	-	-	-	-	-	-
◆ Hard Steels (52-56 HRc)	-	-	-	-	-	-	-	-	-

NOTE: For material families [M] (stainless steel and PH stainless) and [S] (high temperature alloys) the -46 insert geometry is only profile these materials, not slotting.
For D.O.C. please refer to l₁ on page 16.

Star Guide Key to Recommended Inserts

Material Designations	
P ◆ Unalloyed Steels	M ◆ Stainless Steels
P ◆ Alloyed Steels	M ◆ PH Stainless
K ◆ Cast Irons	S ◆ High Temp. Alloys
N ◆ Aluminium & Alloys	H ◆ Hard Materials



Test report

<i>Material:</i>	Alloy Steel
<i>Application:</i>	Profiling
<i>Tool: 40mm Diameter</i>	5315VA12WA040R45
<i>Insert:</i>	ADKT12T3PDER-45
<i>Grade</i>	X500
<i>Radial Depth of Cut: a_e (mm)</i>	15mm
<i>Depth of cut: a_p (mm)</i>	40,5mm
<i>Cutting Speed: V_C (m/min)</i>	89m/min
<i>Spindle Speed: N</i>	708 RPM
<i>Feed: F_z (mm/tooth)</i>	0,12mm

Test report

<i>Material:</i>	Aluminium
<i>Application:</i>	Profiling
<i>Tool: 40mm Diameter</i>	5315VA12WA040R45
<i>Insert:</i>	ADGT12T3PDFR-721
<i>Grade:</i>	GH1
<i>Radial Depth of Cut: a_e (mm)</i>	15mm
<i>Depth of cut: a_p (mm)</i>	39mm
<i>Cutting Speed: V_C (m/min)</i>	400m/min
<i>Spindle Speed: N</i>	3184 RPM
<i>Feed: F_z (mm/tooth)</i>	0,20mm