

5600 V 12 Long Edge Cutter



5600 V 12 Shell Mill Fixation

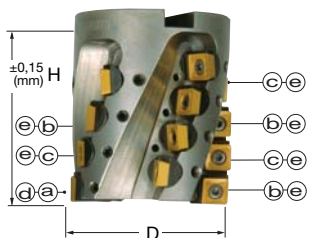
EDP #	Part Number	Dimensions (mm)								No. of Flutes	No. of Inserts	Spares		
		D	L/H	l ₁	l ₂	l ₃	d ₁	Shank	EDP#			EDP#	EDP#	
021684	5600V 12 -A080R070C05	80	92	70	-	-	32	-	5	20	022058	F4009T	015241	T20

5600 V 12 DIN 69871 Fixation

021686	5600V 12 GA063R096C05	63	241	96	120	139	-	50	4	22	022058	F4009T	015241	T20
021688	5600V 12 GA080R096C05	80	240	96	122	138	-	50	5	28	022058	F4009T	015241	T20

5600 V 12 Cartridge Spares

EDP #	Reference to Part Number	EDP #	First Cartridges	EDP #	Other Cartridges	Cartridge			
						EDP#	EDP#	EDP#	EDP#
021684	5600V12-A080R070C05	018937	a. 56SC12R02F X3	018939	b. 56SC12R05P X7	018944	73.612	018945	SW3F
				018938	c. 56SC12R05N X10				
021686	5600V12GA063R096C05	018937	a. 56SC12R02F X2	018939	b. 56SC12R05P X10	018944	73.612	018945	SW3F
				018938	c. 56SC12R05N X10				
021688	5600V12GA080R096C05	018937	a. 56SC12R02F X3	018939	b. 56SC12R05P X12	018944	73.612	018945	SW3F
				018938	c. 56SC12R05N X13				



Shell Mill Fixation

5600 V 12 Body Spares

EDP #	Part Number	Dimensions (mm)								No. of Flutes	No. of Inserts
		D	L/H	l ₁	l ₂	l ₃	d ₁	Shank			
023044	5600V12-A080R070BODY	80	92	70	-	-	32	-	5	20	
023045	5600V12GA063R096BODY	63	241	96	120	139	-	50	4	22	
023046	5600V12GA080R096BODY	80	240	96	122	138	-	50	5	28	



5600 V 12 Technical Advice

Milling Cutter Order Example: **5600V12-A080R070C05**
 Milling Insert Order Example: **SCMT12M512EN-41 MP91M**
 For complete cutting conditions refer to page: 264

Radial depth of cut, as a percentage of cutter diameter

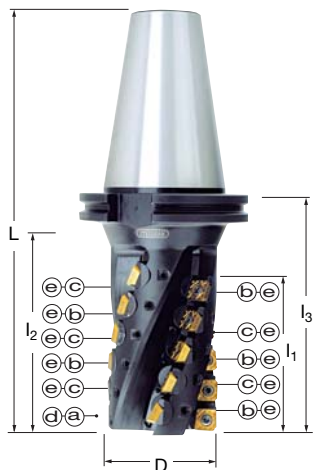
To find programmed feedrate:

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

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

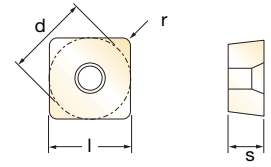
Radial Depth of Cut

% 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

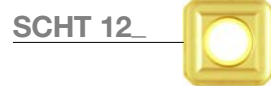


DIN 69871 Fixation

Inserts for 5600 V 12



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017312	SCCT 12 M5ACER	MP91M	▼	▼▼	▼▼▼	12,7	12,7	5,0	Facet	0,03
025811	SCCT 12 M5ACTR	SP4036				12,7	12,7	5,0	Facet	0,15
017695	SCCT 12 M5ACTR	GH1				12,7	12,7	5,0	Facet	0,15
017693	SCCT 12 M5ACTR	SF30				12,7	12,7	5,0	Facet	0,15
017696	SCCT 12 M5ACTR	SFZ				12,7	12,7	5,0	Facet	0,15
017694	SCCT 12 M5ACTR	X44				12,7	12,7	5,0	Facet	0,15
017697	SCHT 12 M5ACTN	PFZ				12,7	12,7	5,0	Facet	0,15
017698	SCHT 12 M5ACTN	X500				12,7	12,7	5,0	Facet	0,15



015144	SCKT 12 M5ACSN-41	X500				12,7	12,7	5,0	Facet	0,12
017314	SCKT 12 M5ACSN-41	MP91M				12,7	12,7	5,0	Facet	0,12
017699	SCKT 12 M5ACSN-41	PFZ				12,7	12,7	5,0	Facet	0,12
024083	SCKT 12 M5ACSN-41	SF30				12,7	12,7	5,0	Facet	0,12



017706	SCMT 12 M508E	SF30				12,7	12,7	5,0	0,8	0,15
024944	SCMT 12 M508E	X44				12,7	12,7	5,0	0,8	0,15
017707	SCMT 12 M512E	SF30				12,7	12,7	5,0	1,2	0,15
017709	SCMT 12 M512T	GH1				12,7	12,7	5,0	1,2	0,15
017316	SCMT 12 M512T	MP91M	♦			12,7	12,7	5,0	1,2	0,15
015227	SCMT 12 M512T	PFZ	♦			12,7	12,7	5,0	1,2	0,15
017708	SCMT 12 M512T	SF30				12,7	12,7	5,0	1,2	0,15
017710	SCMT 12 M512T	SFZ				12,7	12,7	5,0	1,2	0,15
015228	SCMT 12 M512T	X44	♦			12,7	12,7	5,0	1,2	0,15
024129	SCMT 12 M512T	X500				12,7	12,7	5,0	1,2	0,12

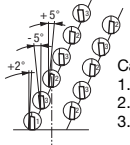


017317	SCMT 12 M512EN-41	MP91M				12,7	12,7	5,0	1,2	0,05
024108	SCMT 12 M512EN-41	PFZ				12,7	12,7	5,0	1,2	0,05
015226	SCMT 12 M512EN-41	X500				12,7	12,7	5,0	1,2	0,05
027732	SCMT 12 M512EN-41	SP6564				12,7	12,7	5,0	1,2	0,05



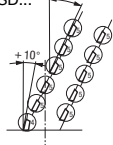
5600V Cartridge Mounting Instructions:

1. Geometry C 05
Positive + Negative (chevron)
inserts SC...



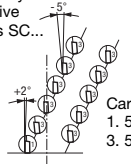
Cartridges
1. 56 SC 12 R 02F
2. 56 SC 12 R 05P
3. 56 SC 12 R 05N

2. Geometry P 2510
Super Positive
inserts SD...



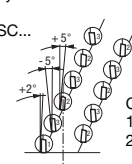
Cartridges
4. 56 SD 12 R 10F
5. 56 SD 12 R 25P

3. Geometry N 0502
Negative
inserts SC...



Cartridges
1. 56 SC 12 R 02F
3. 56 SC 12 R 05N

4. Geometry P 0502
Positive
inserts SC...



Cartridges
1. 56 SC 12 R 02F
2. 56 SC 12 R 05P

S_12 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed/Rev. 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 - 0,60	See I ₁	-	-	-	-	-	-
♦ Alloyed Steels	70 - 110	0,15 - 0,45	See I ₁	-	-	-	-	-	-
♦ Stainless Steels	-	-	-	-	-	-	-	-	-
♦ PH Stainless	-	-	-	-	-	-	-	-	-
♦ Cast Irons	140 - 280	0,15 - 0,80	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	