



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#		
021685	5600V 12 -A080R070P2510	80	92	70	-	-	32	-	-	5	20	022058	F4009T	015241	T20

5600 V 12 DIN 69871 Fixation

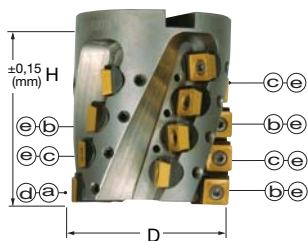
021687	5600V 12 GA063R096P2510	63	241	96	120	139	-	50	4	22	022058	F4009T	015241	T20
021689	5600V 12 GA080R096P2510	80	240	96	122	138	-	50	5	28	022058	F4009T	015241	T20

5600 V 12 Cartridge Spares

EDP #	Reference to Part Number					Cartridge			
		EDP #	First Cartridges	EDP #	Other Cartridges	EDP#		EDP#	
021685	5600V12-A080R070P2510	018942	d. 56SD12R10F X3	018943	e. 56SD12R25P X17	018944	73.612	018945	SW3F
021687	5600V12GA063R096P2510	018942	d. 56SD12R10F X2	018943	c. 56SD12R25P X20	018944	73.612	018945	SW3F
021689	5600V12GA080R096P2510	018942	d. 56SD12R10F X3	018943	e. 56SD12R25P X25	018944	73.612	018945	SW3F

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	



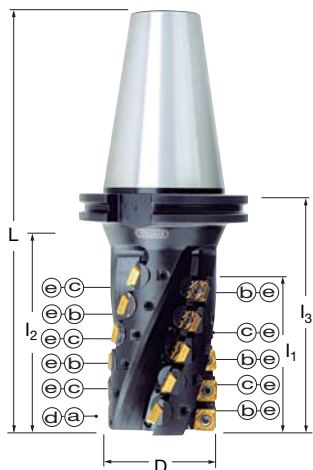
Shell Mill Fixation

See page 153 for cartridge mounting instructions.



5600 V 12 Technical Advice

Milling Cutter Order Example: **5600V12-A080R070P2510**
 Milling Insert Order Example: **SDMT120412EM-41 MP91M**
 For complete cutting conditions refer to page: 264



DIN 69871 Fixation

Radial depth of cut, as a percentage of cutter diameter

To find programmed feedrate:

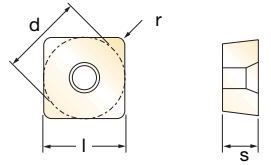
$$h_m = f_z \times \sqrt{\frac{\text{Depth of Cut}}{\text{Cutter diameter}}}$$

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 5600 V 12



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
018203	SDCT 12 04AEEN	SF30				12,7	12,7	4,76	Facet	0,04
017243	SDCT 12 04AEFN	GH1				12,7	12,7	4,76	Facet	0,02
017318	SDCW 12 04AEEN	MP91M				12,7	12,7	4,76	Facet	0,03
017719	SDCW 12 04AEFN	SFZ				12,7	12,7	4,76	Facet	0,02
017722	SDCW 12 04AETN	GH1				12,7	12,7	4,76	Facet	0,15
018205	SDCW 12 04AETN	CN35				12,7	12,7	4,76	Facet	0,17
017720	SDCW 12 04AETN	SF30				12,7	12,7	4,76	Facet	0,15
017723	SDCW 12 04AETN	SFZ				12,7	12,7	4,76	Facet	0,10
017721	SDCW 12 04AETN	X44				12,7	12,7	4,76	Facet	0,15
018206	SDEW 12 0412TN	X500				12,7	12,7	4,76	1,2	0,15
017322	SDHT 12 04AETN-42	MP91M				12,7	12,7	4,76	Facet	0,15
017728	SDHT 12 04AETN-42	PFZ				12,7	12,7	4,76	Facet	0,15
027735	SDHT 12 04AETN-42	SP6564	◆◆			12,7	12,7	4,76	Facet	0,15
017729	SDHT 12 04AETN-42	X500	◆			12,7	12,7	4,76	Facet	0,10
017321	SDHT 12 04AEEN-421	MP91M				12,7	12,7	4,76	Facet	0,04
015133	SDHT 12 04AEEN-421	PFZ				12,7	12,7	4,76	Facet	0,04
015187	SDHT 12 04AEEN-421	X500	◆			12,7	12,7	4,76	Facet	0,04
027734	SDHT 12 04AEEN-421	SP6564				12,7	12,7	4,76	Facet	0,04
017324	SDHW 12 04AETN	MP91M				12,7	12,7	4,76	Facet	0,15
015134	SDHW 12 04AETN	PFZ				12,7	12,7	4,76	Facet	0,15
017730	SDHW 12 04AETN	X500				12,7	12,7	4,76	Facet	0,15
017731	SDHW 15 05AETN	X500				15,88	15,88	5,56	Facet	0,15
026601	SDKT 12 04AEEN-45	MP91M				12,7	12,7	4,76	Facet	0,05
026603	SDKT 12 04AEEN-45	X500				12,7	12,7	4,76	Facet	0,05
027739	SDKT 12 04AEEN-45	SP6564				12,7	12,7	4,76	Facet	0,05
017326	SDMT 12 0412EN-41	MP91M				12,7	12,7	4,76	1,2	0,05
015135	SDMT 12 0412EN-41	PFZ				12,7	12,7	4,76	1,2	0,05
014411	SDMT 12 0412EN-41	X500				12,7	12,7	4,76	1,2	0,05
027737	SDMT 12 0412EN-41	SP6564				12,7	12,7	4,76	1,2	0,05
017328	SDMW 12 0412TN	MP91M				12,7	12,7	4,76	1,2	0,15
015136	SDMW 12 0412TN	PFZ				12,7	12,7	4,76	1,2	0,15
015233	SDMW 12 0412TN	X500				12,7	12,7	4,76	1,2	0,12



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	-	-	-	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,35 - 0,45	See I ₁	-	-	-	-	-	-
◆ Stainless Steels	120 - 140	0,25 - 0,30	See I ₁	-	-	-	-	-	-
◆ PH Stainless	55 - 70	0,25 - 0,30	See I ₁	-	-	-	-	-	-
◆ Cast Irons	-	-	-	-	-	-	-	-	-
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	25 - 40	0,25 - 0,30	See I ₁	-	-	-	-	-	-
◆ 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