



## The 5230VS Series: Cut Machining Time by up to 50% or More

### Shell

50mm – 100mm



- 90 degree roughing
- High Metal Removal Rates
- High Stability and Rigidity
- Square inserts, 4 cutting edges
- Three grades, four geometries
- Shell and Cylindrical construction
- Standard and long series available
- Cutting diameters from 50mm to 100mm
- Insert sizes 9,52mm and 12,70mm
- Depth of cut from 51mm to 133mm

## 5230 Case Histories

Material: Titanium 555-3  
 Cutter: 5230VS12 (63mm Cutter)  
 Component: Landing Gear  
 Industry: Aerospace  
 Insert Grade: X500  
 RPM: 150  
 Cutting Speed  $V_C$ : 29,7 m/min  
 Feed per Tooth  $f_z$ : 0,1 mm/min  
 Feed Rate: 60 mm/min  
 Depth of Cut  $a_p$ : 50mm

***Increased Metal Removal Rate by 300%!***

Material: Titanium 6-4  
 Cutter: 5230VS12 (80mm Cutter)  
 Component: Bulkhead  
 Industry: Aerospace  
 Insert Grade: X500  
 RPM: 275  
 Cutting Speed  $V_C$ : 69,0 m/min  
 Feed per Tooth  $f_z$ : 0,1 mm/min  
 Feed Rate: 148 mm/min  
 Depth of Cut  $a_p$ : 60mm

***Incredible Metal Removal Rate of 43 in<sup>3</sup> / min.***

