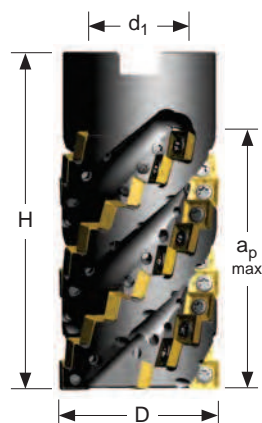


5230VS09

Chevron Long Edge Milling Cutter (Porcupine)

**Shell Mill Fixation**

Product		Dimensions (mm)								Spares				
EDP	Item Description	D	L/H	l ₁	d ₁	ap max	ap max Slotting*	No. of flutes	No. of inserts	EDP		EDP		Screw Tightening Nm
5230VS09 Shell Mill Fixation														
031419	5230VS09-A050Z4R51	50	76	-	27	51	44	4	28	015269	F3508T	015240	T15	2,10
031603	5230VS09-A050Z4R80	50	106	-	27	80	-	4	44	015269	F3508T	015240	T15	2,10

* Note: Please do not surpass the recommended max. ap for slotting.

Shell Mills are supplied with inserts screws, coolant control screws, steel coolant plug, nord-lock washer and mounting screw.

5230VS09 Spare Parts

Cutter	Coolant Control Screw			Screwdriver EDP		Steel Coolant Plug		Coolant Plug tightening Nm
	Screw EDP	Screw	Qty.			EDP	Description	
5230VS09-A050Z4R51	015062	F3006T	8	013214	T9	031436	SB-3413	34
5230VS09-A050Z4R80			12			031582	SB-3621	

5230VS09 Torque Values and Spare Parts

Cutter	Nord Lock Washer		Mounting Bolt		**Torque Values in Nm	
	EDP	Description	EDP	Description	Normal Condition	Excessive Condition
5230VS09-A050Z4R51	031258	NLW-0.375	031268	M12-1.75 ISO x 30mm SHCS	80	100
5230VS09-A050Z4R80						

** Torque values for mounting bolts. Excessive condition is when long reach extensions are required or when cutting parameters are elevated to extreme parameters.

5230VS09 Technical Information (mm)

Product		Dimensions					Max RPM
EDP	Item Description	Facing Pitch	Ramping Angle °	Helical Hole min. - max.		ap max Helical / Linear	
031419	5230VS09-A050Z4R51	50	-	-	-	-	32500
031603	5230VS09-A050Z4R80	50	-	-	-	-	32500

