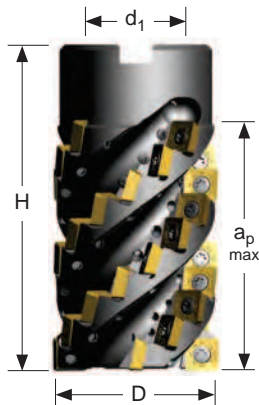


5230VS12

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
5230VS12 Shell Mill Fixation														
031228	5230VS12-A063Z4R57	63	85	-	27	57	52	4	24	015270	F4011T	015241	T20	3,10
031229	5230VS12-A063Z4R94	63	124	-	27	94	-	4	40	015270	F4011T	015241	T20	3,10
031604	5230VS12-A080Z5R65	80	95	-	32	65	60	5	35	015270	F4011T	015241	T20	3,10
031605	5230VS12-A080Z5R110	80	143	-	32	110	-	5	60	015270	F4011T	015241	T20	3,10
031232	5230VS12-A100Z6R76	100	106	-	40	76	70	6	48	015270	F4011T	015241	T20	3,10
031233	5230VS12-A100Z6R133	100	165	-	40	133	-	6	84	015270	F4011T	015241	T20	3,10

* 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.

5230VS12 Spare Parts

Cutter	Coolant control screw			Screwdriver EDP		Steel Coolant Plug		Coolant Plug tightening Nm
	Screw EDP	Screw	Qty.			EDP	Description	
5230VS12-A063Z4R57	015062	F3006T	8	013214	T9	031262	SB-3229	34
5230VS12-A063Z4R94			12			031263	SB-3230	
5230VS12-A080Z5R65			10			031264	SB-3231	
5230VS12-A080Z5R110			15			031265	SB-3232	61
5230VS12-A100Z6R76			12			031266	SB-3233	
5230VS12-A100Z6R133			18			031267	SB-3234	

5230VS12 Torque Values and Spare Parts

Cutter	Nord Lock Washer		Mounting Bolt		**Torque Values in Nm	
	EDP	Description	EDP	Description	Normal Condition	Excessive Condition
5230VS12-A063Z4R57	031258	NLW-0.375	031268	M12-1.75 ISO x 30mm SHCS	80	100
5230VS12-A063Z4R94						
5230VS12-A080Z5R65	031226	NLW-12SP	031269	M16-2 ISO x 40mm SHCS	110	150
5230VS12-A080Z5R110						
5230VS12-A100Z6R76	031259	NLW-16SP	031270	M20-2.5 ISO x 50mm SHCS	120	180
5230VS12-A100Z6R133						

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

5230VS12 Technical Information (mm)

Product		Dimensions					
EDP	Item Description	Facing Pitch	Ramping Angle °	Helical Hole min. - max.		ap max Helical / Linear	Max RPM
031228	5230VS12-A063Z4R57	63	-	-	-	-	21000
031229	5230VS12-A063Z4R94	63	-	-	-	-	21000
031604	5230VS12-A080Z5R65	80	-	-	-	-	18500
031605	5230VS12-A080Z5R110	80	-	-	-	-	18500
031232	5230VS12-A100Z6R76	100	-	-	-	-	16000
031233	5230VS12-A100Z6R133	100	-	-	-	-	16000

