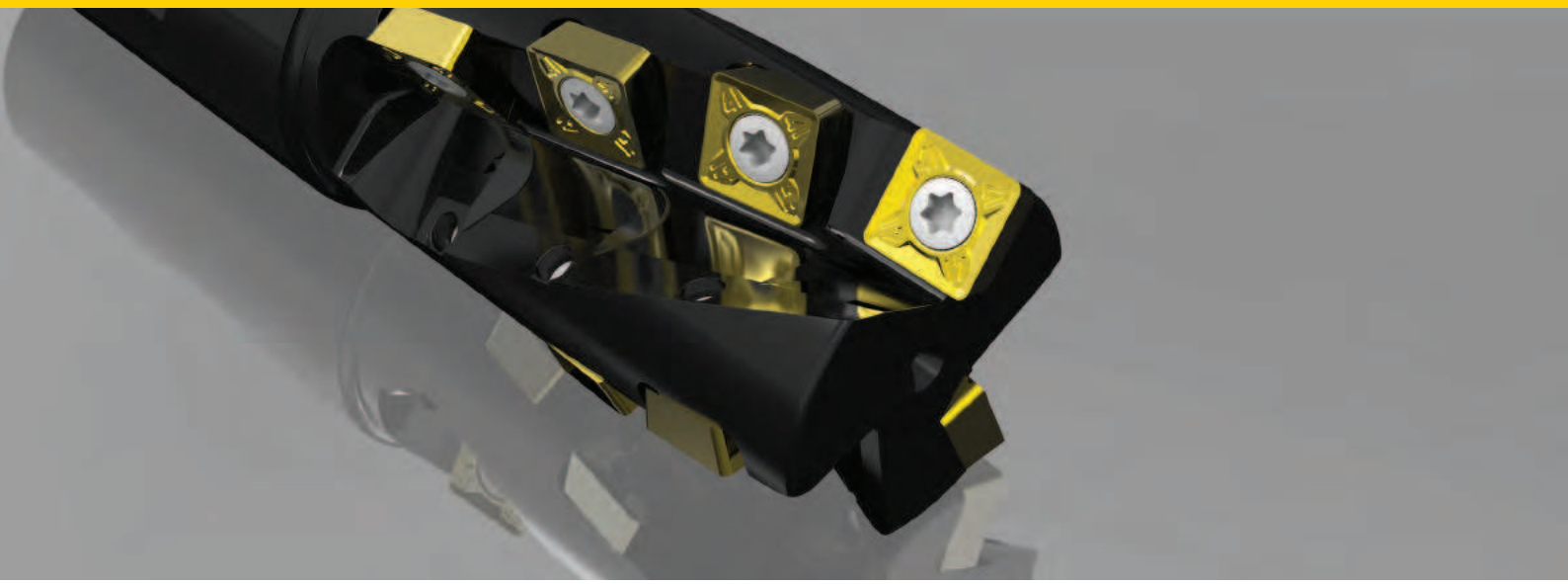


STELLRAM

Shoulder / Profiling

LONG EDGE MILLING CUTTER

The teeth on **5210 VS** cutters are set with a pronounced left hand helix angle. The chosen angle allows, in most cases, at least two teeth to be engaged in the material continuously allowing a progressive attack on the material by each cutting stroke, thereby reducing insert fracture.

A cutter with a left hand helix has the added advantage of absorbing any looseness in the spindle thus reducing vibration. Cutting starts with the top of each tooth which decreases torsion and initial bending of the tool body.

The negative helix allows a large area for chip formation and chip flow. The indexable inserts used on these tools are particularly thick for high shock resistance and also protection of the tool body.

The 5210VS09/12 series is specifically designed for roughing applications on Steel and Cast Iron.

5210VS

5210VS09:
Maximum a_p = 50mm
Diameter Range = 32mm only

5210VS12:
Maximum a_p = 68mm for Diameter 80mm
77mm for Diameter 100mm
Diameter Range = 80mm to 100mm

