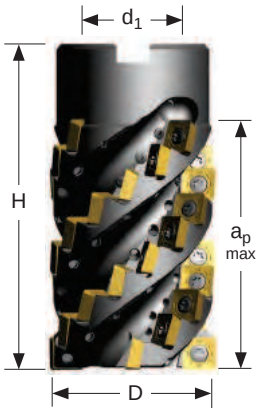
5230VS12
Chevron Long Edge Milling Cutter (Porcupine)

KENNAMETAL

STELLRAM



Shell Mill Fixation

Product		Dimensions (mm)								Spares				
EDP	**Item Description**	D	L/H	l_1	d_1	a_p max	a_p 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. a_p 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	61
5230VS12-A080Z5R110			15			*031265*	SB-3232	
5230VS12-A100Z6R76			12			*031266*	SB-3233	61
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.		a_p 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

