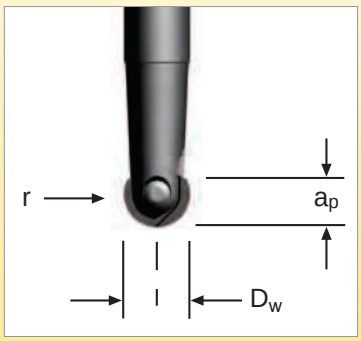
STELLRAM

Contour Mills

## 5500V Technical Information




### Working Diameter:

$$D_w = 2 \times \sqrt{r^2 - (r - a_p)^2}$$

**where:**
**$D_w$** = Working Diameter
**r** = Cutter radius
**$a_p$** = Axial Depth of Cut

## 5500V Technical Information

**where:**
**$f_z$** = Feed per tooth
**$h_m$** = Average chip thickness
**r** = Insert radius
**$a_e$** = Radial Depth of Cut
**$a_p$** = Axial Depth of Cut

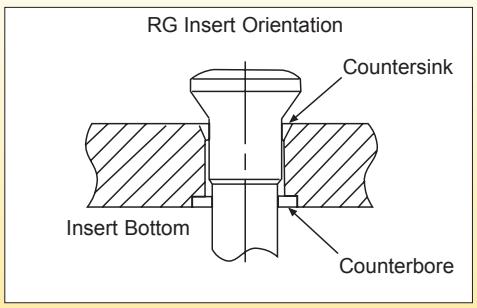
### Average chip thickness: $h_m$

$$h_m = f_z \times \frac{\sqrt{r^2 - (r - a_e)^2}}{r} \times \frac{\sqrt{r^2 - (r - a_p)^2}}{r}$$

### To find programmed feedrate: $f_z$

$$f_z = \frac{h_m}{\frac{\sqrt{r^2 - (r - a_e)^2}}{r} \times \frac{\sqrt{r^2 - (r - a_p)^2}}{r}}$$

## Insert Assembly Information




Insert through hole has a countersink on one side and a counterbore on the other side. Assemble as shown to create proper pull back against the cutter pocket.