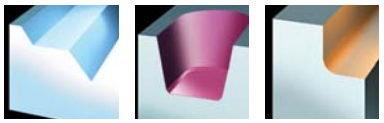
5182 VZ 32

Profile / Pocketing Cutter



5182 VZ 32 Caterpillar Vee Flange*

EDP #	Part Number	Dimensions (inch) D	L	l_2	l_3	$R_{max.}$	a	No. of Inserts	Spares EDP#		EDP#	
018598	**C5182VZ32FA50/1.25R3.00-4**	1.25	8.375	3.00	4.375	4.00	1.25	2	023144	D4008A	015240	T15

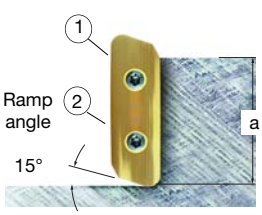
* 40 taper.

Note: Because the overall length of the insert is reduced, as the corner radius increases, the L, l_2, l_3 and a dimensions will reduce/increase as the radius size increases/reduces.

The numbers above assume a 0.157 in. corner radius.

Part number ending -4 means 0.157 in. max radius on insert.
Part number ending -8 means 0.196-.0315 in. radius inserts only.

Caterpillar Vee Flange



Depth of Cut (a)

5182 VZ 32 Technical Advice

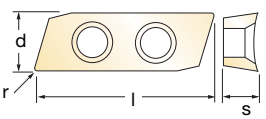
Milling Cutter Order Example: **C5182VZ32FA50/1.25R3.00-4**
Milling Insert Order Example: **ZECX32T330ER-701 SFZ**
For complete cutting conditions refer to page: **208**

Maximum RPM when balanced = 18,000 RPM.
Maximum ramp angle = 15°

Fixing screws:
1) Loosely tighten screws number 1 and 2.
2) Tighten screw number 1 to 31-35 in. lbs.
3) Tighten screw number 2 to 31-35 in. lbs.

Inserts for 5182 VZ 32

EDP#	Part Number	Grade	Application & Material ▼ Roughing	▼▼ Semi-Finishing	▼▼▼ Finishing	Dimensions (inch) d	l	s	r	h_m min
017467	**ZECX32T302ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.469	1.457	0.156	0.008	0.0012
017484	**ZECX32T325ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.469	1.457	0.156	0.098	0.0012
022215	**ZECX32T330ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.469	1.457	0.156	0.118	0.0012
017486	**ZECX32T340ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.469	1.457	0.156	0.157	0.0012
024146	**ZECX32T350ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.470	1.458	0.157	0.196	0.0012
017487	**ZECX32T360ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.471	1.459	0.158	0.236	0.0012
017488	**ZECX32T380ER-701**	**SFZ**	♦	♦	♦♦♦♦	0.472	1.460	0.159	0.315	0.0012



ZECX 32_
-701

* This cutter can be used for finish profiling in these materials, with a maximum 0.040 in. radial depth of cut.

ZE_32 Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (feet/min)	Feed h_m (inch)	a max. (inch)	▼▼ Semi-Finishing Speed V_c (feet/min)	Feed h_m (inch)	a max. (inch)	▼▼▼ Finishing Speed V_c (feet/min)	Feed h_m (inch)	a max. (inch)
♦ Unalloyed Steels	-	-	-	-	-	-	-	-	-
♦ Alloyed Steels	-	-	-	-	-	-	-	-	-
♦ Stainless Steels	-	-	-	-	-	-	-	-	-
♦ PH Stainless	-	-	-	-	-	-	270 - 320	0.002 - 0.003	0.004 - 1.26*
♦ Cast Irons	-	-	-	-	-	-	660 - 1140	0.002 - 0.003	0.004 - 1.26*
♦ Aluminum & Alloys	1650 - 5900	0.004 - 0.010	0.004 - 1.26	1650 - 5900	0.004 - 0.010	0.004 - 1.26	1650 - 5900	0.002 - 0.008	0.004 - 0.59
♦ High Temp. Alloys	-	-	-	-	-	-	150 - 190	0.002 - 0.003	0.004 - 1.26*
♦ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations							
P ♦ Unalloyed Steels	M ♦ Stainless Steels	K ♦ Cast Irons	S ♦ High Temp. Alloys
P ♦ Alloyed Steels	M ♦ PH Stainless	N ♦ Aluminum & Alloys	H ♦ Hard Materials

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