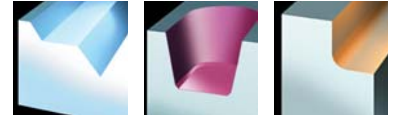




5182 VZ 32

Profile / Pocketing Cutter



5182 VZ 32 DIN 69871 Shank*

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L	l_2	l_3	$R_{max.}$	a		EDP#	 EDP#	 EDP#	
023039	5182VZ 32 GA032R075-4	32	162,5	75	94,1	4	32	a. 2	023144	D4008A	015240	T15
021643	5182VZ 32 GA032R075-8	32	162,5	75	94,1	8	32	b. 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.

These numbers assume a 4.0 mm corner radius.

Part number ending -4 means 4 mm max radius on insert.
Part number ending -8 means 5-8 mm radius inserts only.



DIN 69871 Shank



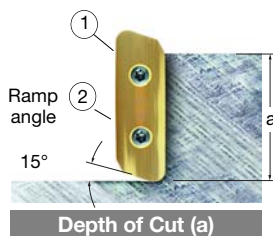
5182 VZ 32 Technical Advice

Milling Cutter Order Example: **5182VZ32GA032R075-4**
Milling Insert Order Example: **ZECX32T330ER-701 SFZ**
For complete cutting conditions refer to page: **264**

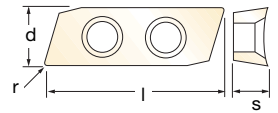
Maximum RPM when balanced = 18,000 RPM.
Maximum ramp angle = 15°

Fixing screws:

- 1) Loosely tighten screws number 1 and 2.
- 2) Tighten screw number 1 to 3.5-4.0 Nm.
- 3) Tighten screw number 2 to 3.5-4.0 Nm.



Inserts for 5182 VZ 32



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017467	ZECX32T302ER-701	SFZ a.	▼	▼▼	▼▼▼	11,9	37,0	3,97	0,2	0,03
017484	ZECX32T325ER-701	SFZ a.	◆	◆	◆◆◆	11,9	37,0	3,97	2,5	0,03
022215	ZECX32T330ER-701	SFZ a.	◆	◆	◆◆◆	11,9	37,0	3,97	3,0	0,03
017486	ZECX32T340ER-701	SFZ a.	◆	◆	◆◆◆	11,9	37,0	3,97	4,0	0,03
024146	ZECX32T350ER-701	SFZ b.	◆	◆	◆◆◆	11,9	37,0	3,97	5,0	0,03
017487	ZECX32T360ER-701	SFZ b.	◆	◆	◆◆◆	11,9	37,0	3,97	6,0	0,03
017488	ZECX32T380ER-701	SFZ b.	◆	◆	◆◆◆	11,9	37,0	3,97	8,0	0,03

ZECX 32_701



* This cutter can be used for finish profiling in these materials, with a maximum 1 mm radial depth of cut.

ZE_32 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed h _m (mm)	a max. (mm)	Speed V _C (m/min)	Feed h _m (mm)	a max. (mm)	Speed V _C (m/min)	Feed h _m (mm)	a max. (mm)
◆ Unalloyed Steels	-	-	-	-	-	-	-	-	-
◆ Alloyed Steels	-	-	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	80 - 100	0,05 - 0,08	0,1 - 32,0*
◆ Cast Irons	-	-	-	-	-	-	200 - 350	0,05 - 0,08	0,1 - 32,0*
◆ Aluminium & Alloys	500 - 1800	0,10 - 0,25	0,10 - 32,0	500 - 1800	0,10 - 0,25	0,10 - 32,0	500 - 1800	0,05 - 0,20	0,1 - 15,0
◆ High Temp. Alloys	-	-	-	-	-	-	45 - 60	0,05 - 0,08	0,1 - 32,0*
◆ 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 ◆ Aluminium & Alloys	H ◆ Hard Materials	