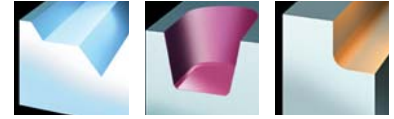


5182 VZ 33

Profile / Pocketing Cutter



5182 VZ 33 DIN 69871 Shank*

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L	l_2	l_3	$R_{max.}$	a		EDP#	EDP#	EDP#	
021644	5182VZ 33 GA040R095-4	40	182,5	95	114,1	4	33	a. 2	015261	D4010A	015240	T15
021645	5182VZ 33 GA040R095-8	40	182,5	95	114,1	8	33	b. 2	015261	D4010A	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



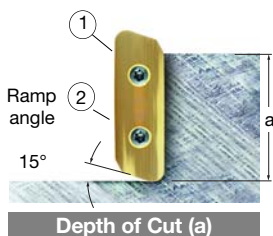
5182 VZ 33 Technical Advice

Milling Cutter Order Example: **5182VZ33GA040R095-4**
Milling Insert Order Example: **ZDCX330430ER-701 SFZ**
For complete cutting conditions refer to page: **264**

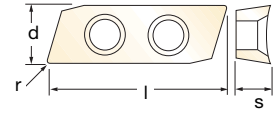
Maximum RPM when balanced = 18,000 RPM.
Maximum ramp angle = 15°

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 33



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017471	ZDCX330402ER-701	SFZ a.	▼	▼▼	▼▼▼	13,5	37,0	4,76	0,2	0,03
017472	ZDCX330425ER-701	SFZ a.	◆	◆	◆◆◆	13,5	37,0	4,76	2,5	0,03
017473	ZDCX330430ER-701	SFZ a.	◆	◆	◆◆◆	13,5	37,0	4,76	3,0	0,03
017474	ZDCX330440ER-701	SFZ a.	◆	◆	◆◆◆	13,5	37,0	4,76	4,0	0,03
024147	ZDCX330450ER-701	SFZ b.	◆	◆	◆◆◆	13,5	37,0	4,76	5,0	0,03
017475	ZDCX330460ER-701	SFZ b.	◆	◆	◆◆◆	13,5	37,0	4,76	6,0	0,03
017476	ZDCX330480ER-701	SFZ b.	◆	◆	◆◆◆	13,5	37,0	4,76	8,0	0,03

ZDCX 33-701



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

ZD_33 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 - 33,0*
◆ Cast Irons	-	-	-	-	-	-	200 - 350	0,05 - 0,08	0,1 - 33,0*
◆ Aluminium & Alloys	500 - 2200	0,10 - 0,25	0,10 - 53,0	500 - 2200	0,10 - 0,25	0,10 - 53,0	500 - 2200	0,05 - 0,20	0,1 - 15,0
◆ High Temp. Alloys	-	-	-	-	-	-	45 - 60	0,05 - 0,08	0,1 - 33,0*
◆ 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