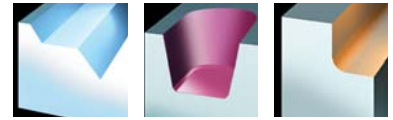


5182 VZ 33

Profile / Pocketing Cutter



5182 VZ 33 Caterpillar Vee Flange*

EDP #	Part Number	Dimensions (inch)							No. of Inserts	Spares		
		D	L	l_2	l_3	R_{max}	a	EDP#		EDP#	EDP#	
018599	C5182VZ33FA50/1.50R4.00-4	1.50	9.375	4.00	5.375	4.00	1.3	2	015261	D4010A	015240	T15

* 50 taper.

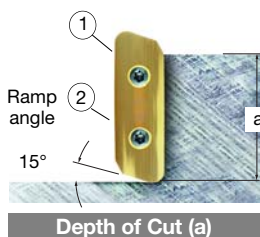
Note: Because the overall length of the insert is reduced, as the corner radius increases, the L, l_2 , l_3 and a dimensions will reduce/increase as the radius size increases/reduces.

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 0.196-0.315 in. radius inserts only.



Caterpillar Vee Flange



5182 VZ 33 Technical Advice

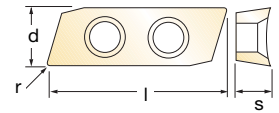
Milling Cutter Order Example: **C5182VZ33FA50/1.50R4.00-4**
Milling Insert Order Example: **ZDCX330430ER-701 SFZ**
For complete cutting conditions refer to page: **208**

Maximum RPM when balanced = 12,000 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 33



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017471	ZDCX330402ER-701	SFZ	◆	◆	◆◆◆	0.531	1.457	0.187	0.008	0.0012
017472	ZDCX330425ER-701	SFZ	◆	◆	◆◆◆	0.531	1.457	0.187	0.098	0.0012
017473	ZDCX330430ER-701	SFZ	◆	◆	◆◆◆	0.531	1.457	0.187	0.118	0.0012
017474	ZDCX330440ER-701	SFZ	◆	◆	◆◆◆	0.531	1.457	0.187	0.157	0.0012
024147	ZDCX330450ER-701	SFZ	◆	◆	◆◆◆	0.532	1.458	0.188	0.196	0.0012
017475	ZDCX330460ER-701	SFZ	◆	◆	◆◆◆	0.531	1.457	0.187	0.236	0.0012
017476	ZDCX330480ER-701	SFZ	◆	◆	◆◆◆	0.531	1.457	0.187	0.315	0.0012

ZDCX 33_
-701



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

ZD_33 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (feet/min)	Feed h _m (inch)	a max. (inch)	Speed V _C (feet/min)	Feed h _m (inch)	a max. (inch)	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 - 1.3*
◆ Cast Irons	-	-	-	-	-	-	660 - 1140	0.002 - 0.003	0.004 - 1.3*
◆ Aluminum & Alloys	1650 - 7210	0.004 - 0.010	0.004 - 1.29	1650 - 7210	0.004 - 0.010	0.004 - 1.29	1650 - 7210	0.002 - 0.008	0.004 - 0.59
◆ High Temp. Alloys	-	-	-	-	-	-	150 - 190	0.002 - 0.003	0.004 - 1.3*
◆ 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
	◆ P	Alloyed Steels	◆ M	PH Stainless	◆ N	Aluminum & Alloys
					◆ S	High Temp. Alloys
					◆ H	Hard Materials