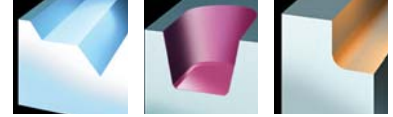


5182 VZ 53

Profile / Pocketing Cutter



5182 VZ 53 Caterpillar Vee Flange

EDP #	Part Number	Dimensions (inch)						No. of Inserts	Spares			
		D	L	l_2	l_3	$R_{max.}$	a		EDP#	EDP#	EDP#	
018600	C5182VZ53FA50/2.00R4.00-4	2.00	8.750	3.38	4.75	4.00	2.08	2	015264	D5010A	015240	T20
018601	C5182VZ53FA50/2.50R5.00-4	2.50	10.380	5.00	6.38	4.00	2.08	2	015264	D5010A	015240	T20

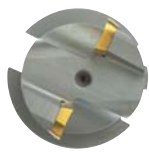
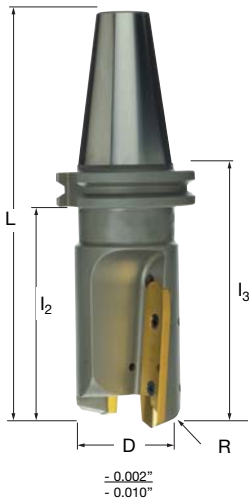
* 50 taper.

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.

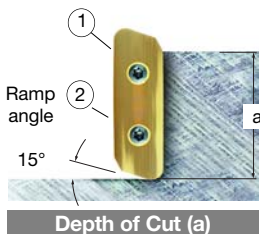
The numbers above assume a 0.157 in. corner radius.

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 53 Technical Advice

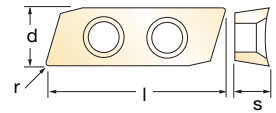
Milling Cutter Order Example: **C5182VZ53FA50/2.50R5.00-4**
 Milling Insert Order Example: **ZDCX530430ER-701 SFZ**
 For complete cutting conditions refer to page: **208**

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 44-48 in. lbs.
- 3) Tighten screw number 2 to 44-48 in. lbs.

Inserts for 5182 VZ 53



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017477	ZDCX530402ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.008	0.0012
017478	ZDCX530425ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.098	0.0012
017576	ZDCX530430ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.118	0.0012
017480	ZDCX530440ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.157	0.0012
022228	ZDCX530450ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.196	0.0012
017481	ZDCX530460ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.236	0.0012
017482	ZDCX530480ER-701	SFZ	◆	◆	◆◆◆	0.583	2.520	0.187	0.315	0.0012

ZDCX 53_701



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

** See maximum RPM.

ZD_53 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 - 2.0*
◆ Cast Irons	-	-	-	-	-	-	660 - 1140	0.002 - 0.003	0.004 - 0.004
◆ Aluminum & Alloys	1650 - 7210	0.004 - 0.010	0.004 - 2.08	1650 - 7210	0.004 - 0.010	0.004 - 2.08	1650 - 7210	0.002 - 0.008	0.004 - 0.59
◆ High Temp. Alloys	-	-	-	-	-	-	150 - 190	0.002 - 0.003	0.004 - 2.08*
◆ 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