

Gen-Z 155

High Performance Machining

Short Series

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner	Z
	62100	155.5.0600.0580.R0050.0130.0570.0200.00.S06D1C01.01	6	6	5,7	58	13	20	R 0.50	5
	62102	155.5.0800.0640.R0050.0180.0760.0250.00.S08D1C01.01	8	8	7,6	64	18	25	R 0.50	5
	62104	155.5.0800.0640.R0100.0180.0760.0250.00.S08D1C01.01	8	8	7,6	64	18	25	R 1.00	5
	62106	155.6.1000.0730.R0050.0220.0950.0300.00.S10D1C01.01	10	10	9,5	73	22	30	R 0.50	6
	62108	155.6.1000.0730.R0100.0220.0950.0300.00.S10D1C01.01	10	10	9,5	73	22	30	R 1.00	6
	62110	155.6.1200.0650.R0050.0360.0000.0000.00.S12D1C01.01	12	12	-	65	36	-	R 0.50	6
	62112	155.6.1200.0870.R0050.0360.0000.0000.00.S12D1C01.01	12	12	-	87	36	-	R 0.50	6
	62114	155.6.1200.0820.R0050.0260.1140.0370.00.S12D1C01.01	12	12	11,4	82	26	37	R 0.50	6
*	62116	155.6.1200.0820.R0100.0260.1140.0370.00.S12D1C01.01	12	12	11,4	82	26	37	R 1.00	6
	62118	155.6.1200.0820.R0200.0260.1140.0370.00.S12D1C01.01	12	12	11,4	82	26	37	R 2.00	6
	62120	155.6.1200.0820.R0300.0260.1140.0370.00.S12D1C01.01	12	12	11,4	82	26	37	R 3.00	6
*	62122	155.6.1600.0930.R0030.0340.1520.0420.00.S16D1C01.01	16	16	15,2	93	34	42	R 0.30	6
*	62124	155.6.1600.0930.R0100.0340.1520.0420.00.S16D1C01.01	16	16	15,2	93	34	42	R 1.00	6
*	62126	155.6.1600.0930.R0200.0340.1520.0420.00.S16D1C01.01	16	16	15,2	93	34	42	R 2.00	6
	62128	155.6.1600.0930.R0300.0340.1520.0420.00.S16D1C01.01	16	16	15,2	93	34	42	R 3.00	6
	62130	155.6.2000.1050.R0300.0420.1900.0520.00.S20D1C01.01	20	20	19	105	42	52	R 3.00	6

Long Series

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner	Z
	62132	155.6.1000.1000.R0100.0400.0000.0000.00.S10D1C01.01	10	10	-	100	40	-	R 1.00	6
	62134	155.6.1200.1000.R0100.0480.0000.0000.00.S12D1C01.01	12	12	-	100	48	-	R 1.00	6
	62136	155.6.1600.1100.R0050.0480.1520.0650.00.S16D2C01.01	16	16	15,2	110	48	65	R 0.50	6
	62138	155.6.1600.1000.R0100.0480.0000.0000.00.S16D2C01.01	16	16	-	100	48	-	R 1.00	6
	62140	155.6.1600.1200.R0200.0640.0000.0000.00.S16D1C01.01	16	16	-	120	64	-	R 2.00	6
	62142	155.6.2000.1650.R0300.0800.0000.0000.00.S20D1C01.01	20	20	-	165	80	-	R 3.00	6
	62144	155.6.2000.1650.R0150.0600.0000.0000.00.S20D2C01.01	20	20	-	165	60	-	R 1.50	6

Cutting Parameters - Trochoidal

Material	Shoulder Milling ap=2x0/ae=0,05-0,120 Vc (m/min)	Shoulder Milling ap=3x0/ae=0,05-0,10 Vc (m/min)	Shoulder Milling ap=4x0/ae=0,05-0,10 Vc (m/min)
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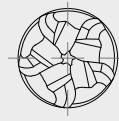


	Unalloyed Steel	220-250	220-250	200-230
Steel	Steel	210-240	210-240	190-220
	Tempered Steel	110-140	110-140	100-120
	Cold Work Tool Steel	80-110	75-105	70-90
	Hot Work Tool Steel	80-110	75-105	70-90
Stainless Steel	AISI 304-416-420	120-150	120-150	95-125
	AISI 316-440	100-130	90-120	80-110
	17-4 PH 15-5 PH	90-120	80-110	70-100
	Chrome-Cobalt Alloy	70-100	70-90	65-85
	Duplex F51	90-130	90-130	70-110
	Super Duplex F55	90-130	90-130	70-110
Cast Iron	Gray Cast Iron	200-235	200-235	195-215
	Alloyed Cast Iron	200-240	200-240	190-220
	Precision Cast Iron	200-245	200-245	190-225
Titanium	Iron-Based Super Alloys	45-65	45-65	40-60
	Nickel-Based Super Alloys	40-55	40-55	40-50
	Titanium-Based Super Alloys	100-120	95-115	90-105

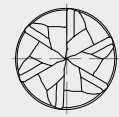
Feed Per Tooth (mm/tooth)

	ap=2x0	ap=3x0	ap=4x0
0			
4	0,016-0,032		
6	0,036-0,072	0,036-0,072	0,04-0,07
8	0,048-0,096	0,048-0,086	0,05-0,08
10	0,075-0,15	0,06-0,12	0,05-0,08
12	0,09-0,18	0,072-0,144	0,06-0,09
14	0,105-0,21	0,084-0,168	0,07-0,1
16	0,12-0,24	0,07-0,1	0,07-0,1
18	0,135-0,27	0,12-0,15	0,12-0,15
20	0,15-0,3	0,12-0,24	0,13-0,16

Z5



Z6



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	○
Cast Iron	○
Graphite	○
Non Ferrous Material	○
HRSA	●
Titanium	●

● Recommended ● Acceptable ○ Not Recommended