



Gen-Z 157

High Performance Machining

S	Order No	Code	d1h9	d2h6	l1	l2	Corner
	64100	157.5.0800.0640.R0050.0240.0800.0290.00.S08B1C01.01	8	8	64	24	R 0.50
	64102	157.5.1000.0730.R0050.0300.1000.0350.00.S10B1C01.01	10	10	73	30	R 0.50
	64104	157.5.1200.0900.R0075.0360.1200.0410.00.S12B1C01.01	12	12	90	36	R 0.75
	64106	157.5.1600.0930.R0100.0480.1600.0530.00.S16B1C01.01	16	16	93	48	R 1.00
	64108	157.5.2000.1100.R0100.0600.2000.0650.00.S20B1C01.01	20	20	110	60	R 1.00
	64110	157.5.2500.1250.R0100.0750.2500.0800.00.S25B1C01.01	25	25	125	75	R 1.00
	64112	157.5.0800.0750.R0050.0320.0800.0350.00.S08B1C01.01	8	8	75	32	R 0.50
	64114	157.5.1000.0850.R0050.0400.1000.0440.00.S10B1C01.01	10	10	85	40	R 0.50
	64116	157.5.1200.1020.R0075.0480.1200.0520.00.S12B1C01.01	12	12	102	48	R 0.75
	64118	157.5.1600.1200.R0100.0640.1600.0700.00.S16B1C01.01	16	16	120	64	R 1.00
	64120	157.5.2000.1420.R0100.0800.2000.0850.00.S20B1C01.01	20	20	142	80	R 1.00
	64122	157.5.2500.1500.R0100.1000.2500.1050.00.S25B1C01.01	25	25	150	100	R 1.00
	64124	157.5.0800.0900.R0050.0400.0800.0480.00.S08B1C01.01	8	8	90	40	R 0.50
	64126	157.5.1000.1000.R0050.0500.1000.0600.00.S10B1C01.01	10	10	100	50	R 0.50
	64128	157.5.1200.1270.R0075.0600.1200.0720.00.S12B1C01.01	12	12	127	60	R 0.75
	64130	157.5.1600.1500.R0100.0800.1600.0930.00.S16B1C01.01	16	16	150	80	R 1.00
	64132	157.5.2000.1650.R0100.1000.2000.1200.00.S20B1C01.01	20	20	165	100	R 1.00
	64134	157.5.2500.2000.R0100.1250.2500.1440.00.S25B2C01.01	25	25	200	125	R 1.00

Cutting Parameters - Trochoidal

Material	Trochoidal ap=1.20 / ae=0.20 - 0.100 Vc (m/min)	Slotting ap=0.50 Vc (m/min)	Shoulder Milling ap=1.50 / ae=0.35 - 0.200 Vc (m/min)
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Steel	Unalloyed Steel	170-200	130-160	150-180
	Steel	170-200	130-160	150-180
	Tempered Steel	160-190	120-150	140-170
	Cold Work Tool Steel	100-130	80-100	90-110
	Hot work tool steel	90-110	70-90	80-100
Stainless Steel	AlSi 304 - 416 - 420	110-130	90-110	100-120
	AlSi 316 - 440	110-130	90-110	100-120
	17-4 PH 15-5 PH	90-110	70-90	80-100
	Chrome-Cobalt alloy	80-100	60-80	70-90
	Duplex F51	70-90	50-70	60-80
Cast Iron	Super Duplex F55	70-90	50-70	60-80
	Gray cast	150-180	120-150	140-160
	Alloyed cast	140-160	110-140	130-150
	Precision cast	130-150	110-130	120-140
	54 HRC	120-150	80-120	110-130
Titanium	HRSA Hastelloy	60-80	40-60	50-70
	HRSA inconel 625	60-80	40-60	50-70
	HRSA inconel 718	60-80	40-60	50-70
	HRSA Nimonic	60-80	40-60	50-70
	Titanium	80-100	60-80	70-90
	Titanium Alloys	80-100	60-80	70-90

Feed Per Tooth (mm/tooth)

Ø	ap=10	ap=0.500	ae=0.350	ae=0.300	ae=0.250	ae=0.200	ae=0.150	ae=0.100
3	0,012	0,015	0,016	0,02	0,022	0,025	0,026	0,03
4	0,02	0,024	0,02	0,023	0,026	0,03	0,032	0,036
5	0,023	0,026	0,023	0,027	0,031	0,036	0,04	0,045
6	0,026	0,03	0,034	0,038	0,043	0,049	0,05	0,06
8	0,033	0,038	0,036	0,042	0,048	0,054	0,06	0,075
10	0,044	0,049	0,045	0,053	0,063	0,07	0,072	0,084
12	0,045	0,051	0,047	0,053	0,064	0,072	0,08	0,088
16	0,056	0,062	0,058	0,064	0,069	0,075	0,09	0,1
20	0,065	0,073	0,066	0,074	0,08	0,092	0,102	0,11

Z5



≤ 52 HRC + AlCrN

FORM HA DIN 6535



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

● Recommended ● Acceptable ○ Not Recommended