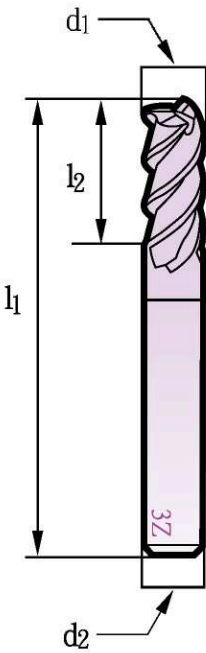
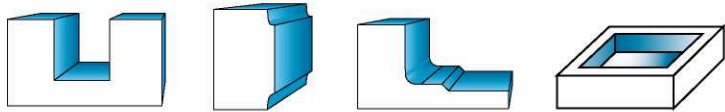


3Z



Order Code	$\varnothing d_1$ (h10)	l_2	l_1	$\varnothing d_2$ (h8)
3Z030	3.0	7.0	57	6.0
3Z040	4.0	8.0	57	6.0
3Z050	5.0	10.0	57	6.0
3Z060	6.0	10.0	57	6.0
3Z080	8.0	16.0	63	8.0
3Z100	10.0	19.0	72	10.0
3Z120	12.0	22.0	83	12.0
3Z160	16.0	26.0	92	16.0
3Z200	20.0	32.0	104	20.0

mm

3Z Recommendations for Cutting Conditions

WORKMaterial	S45C, P20S, FCD		SUS403, SKD11, SCR		Ti-6Al-4V PRE/HARDENED STEELS	
	<HRC30		<HRC30-45		<HRC45-65	
	R. P. M.	Feed	R. P. M.	Feed	R. P. M.	Feed
3Z030	26000	3030	25000	2910	24000	2800
3Z040	22000	3300	21000	3150	20000	3000
3Z050	21000	3150	20000	3000	19000	2850
3Z060	20000	3330	19000	3160	18000	3000
3Z080	18000	4500	17000	4250	16000	4000
3Z100	16000	4570	15000	4280	14000	4000
3Z120	15500	4420	14500	4140	13500	3850
3Z160	9300	2660	9100	2600	8500	2430
3Z200	9380	3130	8750	2910	6880	2290

Max
Milling
Volume

$d_2 < 3.0\text{mm}$
 $l_2 < 0.02d_2$

$l_2 < 0.05d_2$
 $W < 0.05d_2$

$d_2 < 3.0\text{mm}$
 $l_2 < 0.02d_2$

$l_2 < 0.05d_2$
 $W < 0.02d_2$