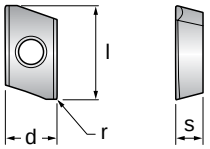
STELLRAM



ZDCX14-701



Product			Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼					
EDP	Item Description	Grade	Depth of Cut (mm)			d (IC)	l	s	r	h_m min
			a_p max. 12*	a_p min. - max. 1,00 - 4,00	a_p min. - max. 0,20 - 1,00					
029027	**ZDCX1403PDFR-701**	**GH1**	♦	♦	♦	7,59	16,83	3,18	Facet	0,02
029028	**ZDCX140320FR-701**	**GH1**	♦	♦	♦	7,59	16,83	3,18	2,0	0,02
026019	**ZDCX140325FR-701**	**GH1**	♦	♦	♦	7,59	16,83	3,18	2,5	0,02
029029	**ZDCX140330FR-701**	**GH1**	♦	♦	♦	7,59	16,83	3,18	3,0	0,02
026020	**ZDCX140340FR-701**	**GH1**	♦	♦	♦	7,59	16,83	3,18	4,0	0,02

Machining Choice: ♦ 1st Choice ■ 2nd Choice ● 3rd Choice | Material Guide Key descriptions found on page A5.

* Max. possible a_p of 12mm and a_e the full diameter (depending on the application).
* For Slotting applications with 5702VZD14 series the maximum a_p is 6mm.



5702VZD Feeds f_z (mm/tooth)

Size	Geometry	Grade	Operation	Aluminium & Alloys <16% Si 116 HBN	Aluminium & Silicon >16% Si 92 HBN
				Min. - Max.	Min. - Max.
14mm	FR-701	GH1	Profile/ Pocketing	0,02 - 0,25	0,02 - 0,20

Speed v_c (m/min)

5702VZD Series			K10-K20/C3 - C2 ISO / ANSI	
			Speed min. - max.	
Coolant Recommendation Recommended ● Possible ⦿				Uncoated Micrograin
ISO	Materials	Rm and Hardness		GH1
N	Aluminium & Alloys	Aluminium & Alloys < 16% Si 116 HBN	●	400 - 3050
		Aluminium + Silicon > 16% Si 92 HBN	●	295 - 2440