STELLRAM

Calculation of the average chip thickness in relation with the a_e (Radial Engagement) if a_e is less than 50% of Dia.

Formula: Programme Feed Rate (f_z)

$$f_z = h_m \times \sqrt{\frac{d}{a_e}}$$

h_m = Average chip thickness
a_e = Radial engagement
f_z = Feed per tooth
d = Cutter diameter

Formula: Average Chip Thickness (h_m)

$$h_m = f_z \times \sqrt{\frac{a_e}{d}}$$

5702VZD14 Ramp Angle °					
Insert ZDCX1403...FR-701 (Radius mm)					
Cutter dia.	Facet	2,0mm	2,50mm	3,00mm	4,00mm
20mm	11.0	9.8	9.0	8.0	6.3

*For Slotting applications with 5702VZD14 series the maximum a_p is 6mm.

These tools are designed, manufactured, tested and balanced in accordance with EN ISO 15641:2001 for maximum stability in high speed applications.

Metal Removal		
Calculated with 24000 RPM		
Cutter	Z	Qmax - cm^3/min
20	**2**	**720**

The chart above shows total metal removal capacity (based on 24,000 RPM) by cutter diameter and number of teeth (2).

The maximum RPM is engraved on all cutter bodies.