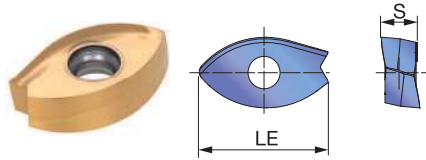


INSERT

ZRBM...



Designation	RE	Coated										LE	S
		APH730											
ZRBM160-MM	8	●										12.4	3.7
ZRBM200-MM	10	●										14.9	4.8
ZRBM250-MM	12.5	●										18.9	5.9

● : Line up
5 piece per package

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Selection criteria	Recommended grade	Chip-breaker	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
P	Low carbon steel S15C, etc. C15, etc.	- 300HB	First choice	APH730	MM	150 - 350	0.08 - 0.6
	High carbon and alloy steel S55C, SCM440, etc. C55, 42CrMo4, etc.	- 300HB	First choice	APH730	MM	120 - 320	0.05 - 0.5
	Prehardened steels NAK80, PX5 etc.	30 - 40HRC	First choice	APH730	MM	100 - 200	0.05 - 0.5
M	Austenitic stainless steel SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc.	- 200HB	First choice	APH730	MM	100 - 280	0.05 - 0.6
	Martensitic stainless steel SUS420J1, etc. X20Cr13, etc.	- 200HB	First choice	APH730	MM	100 - 300	0.05 - 0.6
K	Gray cast irons FC250, etc. 250, etc.	150 - 250HB	First choice	APH730	MM	120 - 380	0.08 - 0.6
	Ductile cast iron FCD600, etc. 600-3, etc.	150 - 250HB	First choice	APH730	MM	100 - 280	0.08 - 0.6
S	Titanium alloy Ti-6Al-4V, etc.	-	First choice	APH730	MM	20 - 80	0.05 - 0.6
	Heat-resistance alloys Inconel718, etc.	-	First choice	APH730	MM	20 - 60	0.05 - 0.4
H	Hardened steel SKD61, etc. X40CrMoV51, etc.	40 - 50HRC	First choice	APH730	MM	40 - 80	0.05 - 0.2
	Hardened steel SKD11, etc. X153CrMoV12, etc.	50 - 60HRC	First choice	APH730	MM	30 - 60	0.04 - 0.14

The above cutting parameters are for reference. Adjustments may be required depending on applications, machine powers and rigidity, and/or workpiece fixture/clamping methods.

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