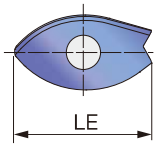
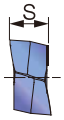
INSERT

ZRBM...





P	Steel	★
M	Stainless	☆
K	Cast iron	☆
N	Non-ferrous	
S	Superalloys	☆
H	Hard materials	☆

★ : First choice
☆ : Second choice

Designation	RE	Coated APH730	LE	S
ZRBU062-MM	0.313	●	0.586	0.118
ZRBU075-MM	0.375	●	0.648	0.146
ZRBU100-MM	0.5	●	0.865	0.177

●: Line up
Pack quantity = 5 pcs.

Standard cutting conditions

ISO	Workpiece materials	Hardness	Selection criteria	Recommended grade	Chip-breaker	Cutting speed *Vc* (sfm)	Feed per tooth *fz* (ipt)
P	Low carbon steel (1015, 1020, etc.)	- 200 HB	First choice	APH730	MM	490 - 1145	0.004 - 0.024
	High carbon and alloy steel (1055, 4140, etc.)	- 300HB	First choice	APH730	MM	390 - 1045	0.002 - 0.020
	Prehardened steels (NAK80, PX5, etc.)	30 - 40HRC	First choice	APH730	MM	325 - 655	0.002 - 0.020
M	Austenitic stainless steel (304SS, 316SS, etc.)	- 200HB	First choice	APH730	MM	325 - 915	0.002 - 0.024
	Martensitic stainless steel (420SS etc.)	- 200HB	First choice	APH730	MM	325 - 980	0.002 - 0.024
K	Gray cast irons (Class 25, Class 30, etc.)	150 - 250HB	First choice	APH730	MM	390 - 1245	0.004 - 0.024
	Ductile cast iron (60-40-18, 80-55-06, etc.)	150 - 250HB	First choice	APH730	MM	325 - 915	0.004 - 0.020
S	Titanium alloy (Ti-6Al-4V, etc.)	-	First choice	APH730	MM	65 - 260	0.002 - 0.024
	Heat-resistant alloys (Inconel718, etc.)	-	First choice	APH730	MM	65 - 195	0.002 - 0.016
H	Hardened steel (H13 etc.)	40 - 50 HRC	First choice	APH730	MM	130 - 260	0.002 - 0.008
	Hardened steel (D2, etc.)	50 - 60 HRC	First choice	APH730	MM	95 - 195	0.002 - 0.008

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