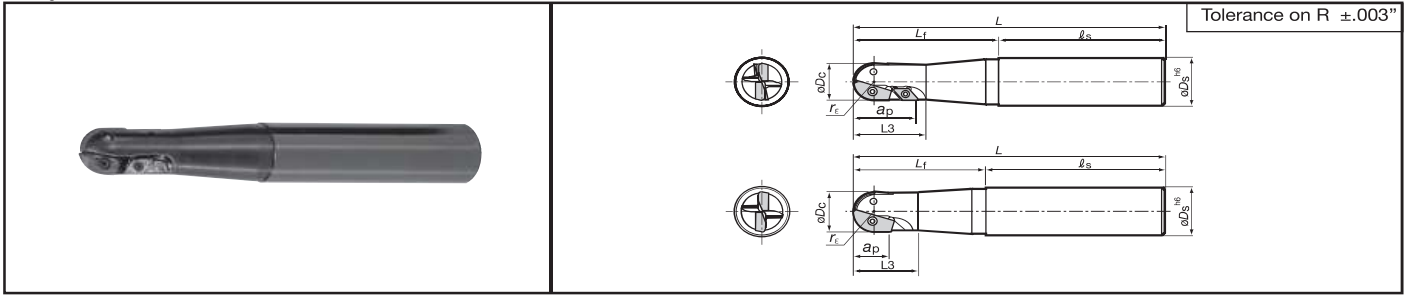


For medium to finish engraving of steel and cast iron dies

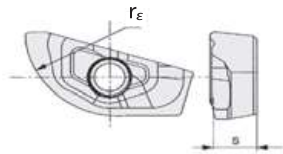


Tolerance on R ±.003"

Cat. No.	Stock	No. of inserts	Dimensions (in)							Applicable inserts		Clamping screw		Wrench		
			ϕD_c	L	L_f	L_s	L_3	ϕD_s	ap	r_E	For R-edge	For peripheral edge	For R-edge	For peripheral edge	For R-edge	For peripheral edge
EBP075MWU	●	2	.750	5.03	2.75	2.28	1.25	1.00	.625	.375	ZPET075MJ	-	CSTD-3T	-	T-10D	-
EBP100MWU	●		1.00	5.53	3.25		-	1.00	.827	.500	ZPET100MJ	-	CSTB-4S	-	T-15D	-
EBP125MWU	●		1.25	6.03	3.75		-	1.25	1.00	.625	ZPET125MJ	-	CSTB-5S	-	T-20D	-
EBP075LWEU	●	2+2	.750	6.03	3.75	2.28	1.25	1.00	1.14	.375	ZPET075MJ	DCMW070204TN	CSTD-3T	CSTB-2.5S	T-10D	T-8D
EBP100LWEU	●		1.00	6.53	4.25		-	1.00	1.61	.500	ZPET100MJ	DCMW11T304TN	CSTB-4S	CSTB-4S	T-15D	T-15D
EBP125LWEU	●		1.25	7.03	4.75		-	1.25	1.81	.625	ZPET125MJ	DCMW11T304TN	CSTB-5S	CSTB-4S	T-20D	T-15D

Inserts

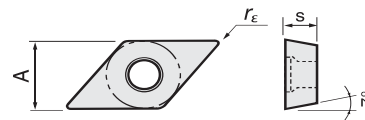
For R-edge



Cat. No.	Accuracy	Honing	Stocked grade		Dimensions (in)	
			Coated		s	r_E
			AH120	AH330		
ZPET075-MJ	E	With	●	●	.177	.375
ZPET100-MJ			●	●	.182	.500
ZPET125-MJ			●	●	.266	.625

"ZPET3006-MJ" : Packing Quantity=1pcs.

For peripheral edge

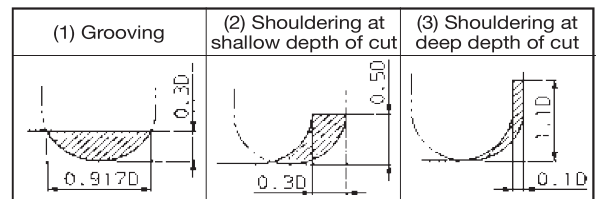


Cat. No.	Accuracy	Honing	Stocked grade		Dimensions (in)		
			Coated		A	s	r_E
			AH120	AH330			
DCMW070204TN	M	With	●	●	.250	.094	.016
DCMW11T304TN			●	●	.375	.156	

Standard cutting conditions

Work material	Grade	Machining type	Cutting speed Vc (SFM)	Table feed v_f (in/min)		
				Tool dia. : ϕ .750	Tool dia. : ϕ 25	Tool dia. : ϕ 30
Carbon steels (1055 etc.) < 300 HB	AH120	(1)	550 ~ 750	24 ~ 30	18 ~ 30	14 ~ 26
		(2)	650 ~ 850	35 ~ 51	27 ~ 43	21 ~ 37
		(3)	500 ~ 650	14 ~ 23	12 ~ 24	9 ~ 21
Alloy steels (4140, 4340) < 300 HB	AH120	(1)	500 ~ 690	21 ~ 33	16 ~ 28	12 ~ 24
		(2)	590 ~ 780	32 ~ 47	16 ~ 32	19 ~ 34
		(3)	425 ~ 590	14 ~ 26	10 ~ 22	8 ~ 19
Die steels (JIS SKD11 etc.) < 300 HB	AH330	(1)	400 ~ 590	17 ~ 28	12 ~ 24	9 ~ 21
		(2)	500 ~ 690	26 ~ 42	19 ~ 35	15 ~ 30
		(3)	330 ~ 500	10 ~ 22	7 ~ 19	5 ~ 17
Cast irons (JIS CLASS 25-40)	AH120	(1)	550 ~ 750	32 ~ 43	24 ~ 36	19 ~ 31
		(2)	650 ~ 850	35 ~ 55	28 ~ 47	21 ~ 41
		(3)	500 ~ 650	17 ~ 28	12 ~ 24	9 ~ 21
Hardened steels Prehardened steels < A980	AH120	(1)	200 ~ 330	6 ~ 14	4 ~ 12	4 ~ 10
		(2)	230 ~ 425	6 ~ 18	4 ~ 16	4 ~ 14
		(3)	130 ~ 260	6 ~ 10	4 ~ 8	3 ~ 7

Machining types



Notes:

- Cutting speeds shown in the left table are of the most outer diameter of the tool.
- When the depth of cut is the upper limit shown in the above figures, set the cutting conditions to the lowest values shown left.
- When using long edge types (MSE), set the cutting speed and feed to 60 to 80 % of values shown in the table.
- When using long shank types (LSE), set the cutting speed and feed to 20 to 50 % of values shown in the table, bearing in mind the overhang length.

● : Stocked items.