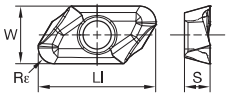
ZDET-ER721




ZDET-ER721

● first choice
○ alternate choice

| | |
|---|---|
| P | |
| M | |
| K | |
| N | ● |
| S | |
| H | |

## ZDET-ER721

| | catalogue number | Ll | W | S | Rε | hm | GH1 |
|---|---|---|---|---|---|---|---|
| NEW! | **ZDET16M525ER721** | 23,02 | 11,25 | 5,00 | 2,6 | 0,03 | ● |
| NEW! | **ZDET16M530ER721** | 23,02 | 11,25 | 5,00 | 3,1 | 0,03 | ● |
| | **ZDET16M540ER721** | 23,02 | 11,25 | 5,00 | 4,1 | 0,03 | ● |

NOTE: Inserts will be delivered with two screws. Because of heavy force to the screw, it is important to change the screw when changing the insert.



## Recommended Starting Speeds

### Recommended Starting Speeds [m/min]

| Material Group | | GH1 | | |
|---|---|---|---|---|
| P | 1 | – | – | – |
| | 2 | – | – | – |
| | 3 | – | – | – |
| | 4 | – | – | – |
| | 5 | – | – | – |
| | 6 | – | – | – |
| M | 1 | – | – | – |
| | 2 | – | – | – |
| | 3 | – | – | – |
| K | 1 | – | – | – |
| | 2 | – | – | – |
| | 3 | – | – | – |
| N | 1–2 | 3050 | **1725** | 400 |
| | 3 | 2440 | **1370** | 295 |
| S | 1 | – | – | – |
| | 2 | – | – | – |
| | 3 | – | – | – |
| | 4 | – | – | – |
| H | 1 | – | – | – |

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

## Recommended Starting Feeds

### Recommended Starting Feeds [mm]

| Light Machining | General Purpose | Heavy Machining |
|---|---|---|

| Insert Geometry | Programmed Feed per Tooth (fz) at % Radial Depth of Cut (ae) of Working Diameter (Dw) | | | | | | | | | | | | Insert Geometry |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 10% | | | 20% | | | 30% | | | 40–100% | | | |
| ...FR721 | 0,03 | **0,33** | 0,41 | 0,025 | **0,25** | 0,31 | 0,021 | **0,21** | 0,27 | 0,02 | **0,2** | 0,25 | ...FR721 |
| ...ER721 | 0,07 | **0,33** | 0,41 | 0,06 | **0,25** | 0,31 | 0,05 | **0,21** | 0,27 | 0,04 | **0,2** | 0,25 | ...ER721 |

NOTE: Use “Light Machining” values as starting feed rate.
% = ae/Dc * 100 (ae = radial depth of cut, Dc = cutting diameter)