

Dijet-Mill

METRIC

FACE MILL

ZNP90 Type

- Shoulder milling for cast iron, steel & non-ferrous materials.

Entering Angle : 90°	A.R. : +7°
	R.R. : +5°
Max. D.O.C.	14mm

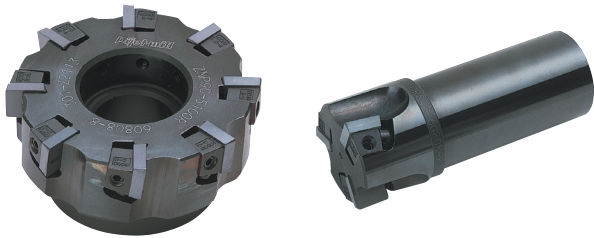


Fig. 1

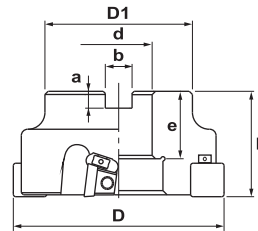
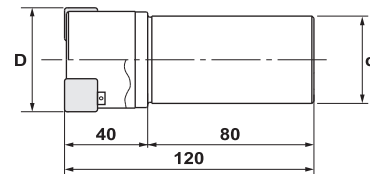


Fig. 2



Specifications

CATALOG NUMBER	STK	DIMENSIONS							FIG.	INSERT	Q	PARTS		
		D	D1	L	d	a	b	e				Wedge Wrench	Wedge / Screw	Adjustable Rest Button / Wrench
ZNP90-5080R	•	80	60	44	25.4	6	9.5	24	1	S56PP-R3M SPMN150408	6	A-030	60808-8 LS-1	ASW-113 AD-1845
ZNP90-5100R	•	100	70	50	31.75	8	12.7	32	1		8			
ZNP90-5125R	•	125	85	54	38.1	10	15.9	36	1		8			
ZNP90-5160R	•	160	100	56	50.8	11	19	37	1		12			
ZNP90-5050S32	•	50	-	120	32	-	-	-	2		3		60808-8 LS-101	
ZNP90-5050S42	•	50	-	120	42	-	-	-	2		3			

Note: All cutters are supplied without inserts.

INSERTS

Fig. 1

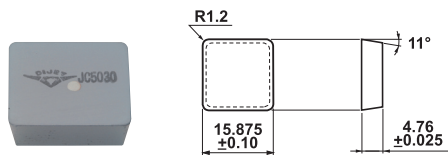
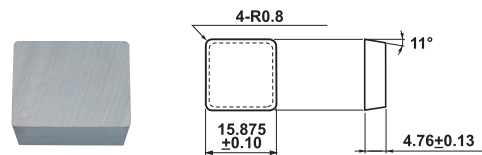


Fig. 2



Specifications

CATALOG NUMBER	DIMENSIONS		FIG.	COATED		UNCOATED
	IC	T		JC5030	JC610	KT9
S56PP-R3M	15.875	4.76	1	•	•	•
SPMN150408	15.875	4.76	2			•

Recommended Cutting Data

WORK MATERIALS	INSERT GRADE	Vc (m/min)	fz (mm/tooth)
Low Carbon Steel (180-280HB)	JC5030	100 - 250	0.1 - 0.3
High Carbon Steel (180-280HB)	JC5030	100 - 200	0.1 - 0.3
Mold Steel & Alloy Steel (180-280HB)	JC5030	80 - 150	0.1 - 0.2
Stainless Steel (~270HB)	JC5030	80 - 150	0.1 - 0.2
Cast Iron (200-250HB)	JC610, KT9	100 - 250	0.1 - 0.4
Ductile Iron (180-250HB)	JC610, KT9	100 - 220	0.1 - 0.4