



PCD STANDARD MILLING CUTTER



Z-CUTTER

LASER MACHINING CUTTING EDGE NEW TECHNOLOGY

Laser machining cutting edge quality is much higher than traditional grinding, no wear, no carbonization phenomenon, and can maintain the integrity of the cutting edge in long time processing, as well as the consistency of the surface roughness, improve the tool life and production efficiency.

BETER QUALITY AND HIGH EFFICIENCY MILLING

No matter what type of milling you are facing, or you want to learn how to improve efficiency, stability and tool life, Zhengzuan can provide high efficiency and significant performance milling solutions to help you achieve cost-saving and industry upgrading purpose.

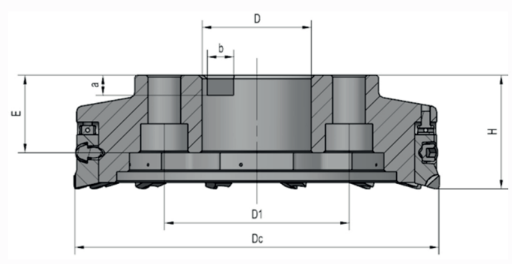
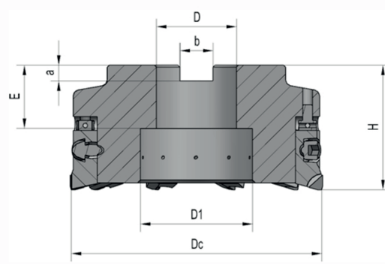
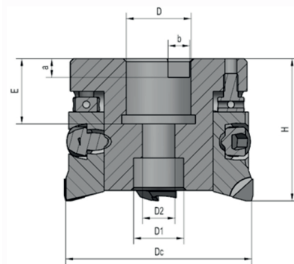
Z-CUTTER MF90 SERIES MILLING CUTTER ADVANTAGES

MF90 milling cutter not only can meet customer's variety of surface quality request, but also can used for several milling ways, such as end face milling, square shoulder milling, continuous milling, interrupted milling and other special milling way.

This series possess high stability and it is applied for machining in high feed rate.

Mainly applied for finish machining. Convenient and efficient operation. Milling cartridge can be located fastly.

Supply for milling cutter customized service and cartridge regrind service.



Specification 1

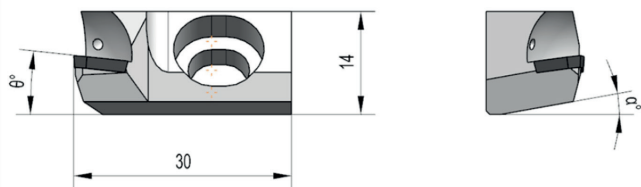
Specification 2

Specification 3

MODEL	PARAMETER									
	Dc (mm)	Z	D (mm)	D1 (mm)	D2 (mm)	E (mm)	b (mm)	a (mm)	H (mm)	Weight (KG)
MF90D063Z04	63	4	22	18	11	22	10.4	6.3	48	0.4
MF90D080Z06	80	6	27	33	/	23	12.4	7	50	0.7
MF90D100Z08	100	8	32	43	/	25	14.4	8	1.1	1.1
MF90D125Z10	125	10	40	56	/	32	15.5	9	2.2	2.2
MF90D160Z12	160	12	40	66.7	/	39.5	16.5	9	3	3
MF90D200Z14	200	14	60	101.6	/	43	25.7	14	4.2	4.2
MF90D250Z20	250	20	60	101.6	/	43	25.7	14	6.5	6.5

Miling cutter

Parameters for cartridge



Face mill cutter cartridge	Type	Rake Angle α (°)	Maximum Cutting Depth a_p (mm)	Tips Material
	MI30-750605-C	6	5	PCD
	MI30-750305-C	3	5	PCD
	MI30-750005-C	0	5	PCD
Shoulder mill cutter cartridge	Type	Rake Angle α (°)	Maximum Cutting Depth a_p (mm)	Tips Material
	MI30-900605-C	6	5	PCD
	MI30-900305-C	3	5	PCD
	MI30-900005-C	0	5	PCD
Top-quality surface mill cutter cartridge	Type	Rake Angle α (°)	Maximum Cutting Depth a_p (mm)	Tips Material
	MI30-0605-J	6	5	PCD
	MI30-0005-J	0	5	PCD
Pt mill cutter cartridge	Type	Rake Angle α (°)	Maximum Cutting Depth a_p (mm)	Tips Material
	MI30-0005-PT	0	5	PCD

Recommended cutting condition

ISO	Workpiece Material	Hardness	Cutting Speed V_c (m/min)	Feed Rate F_z (m/min)
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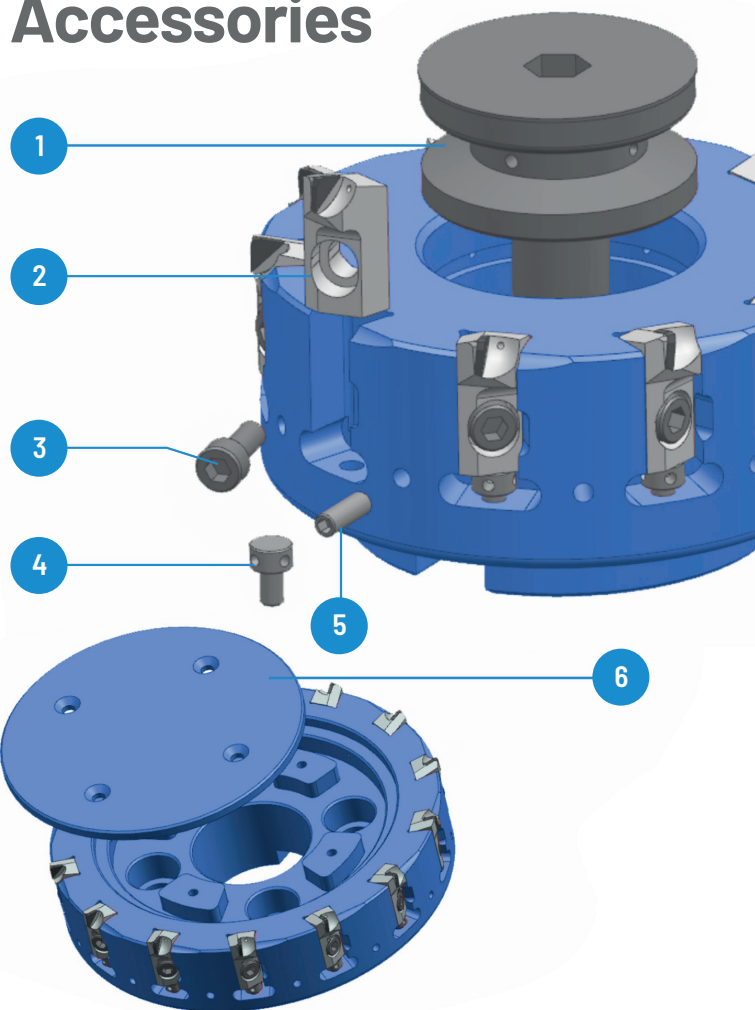
Content of Si below 12.6%

N	Al alloy	-	1500 - 2000 - 3000 Floor-recommend-caps	0.05 - 0.10 - 0.20 Floor-recommend-caps
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Content of Si below 12.6%

N	Al alloy	-	600 - 1000 - 1500 Floor-recommend-caps	0.05 - 0.10 - 0.20 Floor-recommend-caps
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Accessories




Sketch	No.	Name	Material	Type
	1	Forcing screw (used for under 160)	Steel	
	2	Cartridge	Steel+PCD	
	3	Hexagon socket cap screws (house cartridge)	-	M6x20
	4	Adjusting screws with hole (adjust screws)	-	M5x12
	5	Hexagon socket socket head screws (dynamic balancing)	-	M5x15
	6	End housing (used for \varnothing 160 or above 160)	Al alloy	



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You can count on us to support you with the optimization and cost reduction on your machining processes

