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Specials

Inserts

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Cavity Mold

Gray Iron

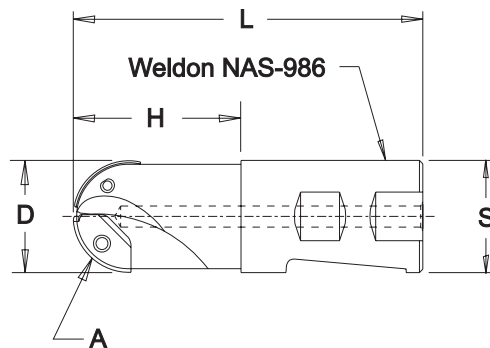
PCD / CBN

Slotters

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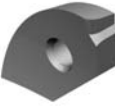
Ball Nose End Mills



• Through Coolant Design

539 Series - Dimensional Specifications

Product Number	D	S	L	A	H	Insert	Teeth	Flutes	Weight
539E0100ACZP2.5-WA100R	1.00	1.00	3.78	Radii	1.50	CZPEB-2.52A-100R	2	2	0.75
539E0100BCZP2.5-WA100R	1.00	1.00	5.28	Radii	3.00	CZPEB-2.52A-100R	2	2	1.00
539E0125ACZP3.5-WA125R	1.25	1.25	3.78	Radii	1.50	CZPEB-3.53A-125R	2	2	1.25
539E0125BCZP3.5-WA125R	1.25	1.25	5.28	Radii	3.00	CZPEB-3.53A-125R	2	2	1.75
539E0150ACZP4-WA125R	1.50	1.25	5.28	Radii	3.00	CZPEB-43A-150R	2	2	2.25
539E0150BCZP4-WA125R	1.50	1.25	7.28	Radii	5.00	CZPEB-43A-150R	2	2	3.25
539E0200ACZP5-WA200R	2.00	2.00	6.25	Radii	3.00	CZPEB-53A-200R	2	2	5.50
539E0200BCZP5-WA200R	2.00	2.00	8.25	Radii	5.00	CZPEB-53A-200R	2	2	7.25

Insert I.C. x Thickness	 Insert Pg. 33	 Insert Pg. 33	 Insert Screw	 Insert Screw Wrench
.492 x .125	CZPEB-2.52A-100R	CZPEH-2.52A-100R	3605-0001-0005	1557-TX10
.618 x .188	CZPEB-3.53A-125R	CZPEH-3.53A-125R	3605-0001-0005	
.745 x .188	CZPEB-43A-150R	CZPEH-43A-150R	3605-0001-0023	
.996 x .188	CZPEB-53A-200R	CZPEH-53A-200R	3605-0001-0023	

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Cast Iron, Class 30	350-850	.002-.005	GR 586XRm	GR LTC-10
Tool Steel, D2	300-700	.003-.010	GR 606jRm	GR LTC-14
Ductile Iron	350-850	.002-.005	GR 606jRm	GR LTC-14
Medium Alloy Steel	300-700	.002-.005	GR 606jRm	GR LTC-14
Tool Steel, P20	300-700	.003-.010	GR 606jRm	GR LTC-14

- Precision ground inserts produce accurate ball configuration
- Free cutting geometry performs on all workpiece materials
- Multiple style insert geometries extend application range
- Multifunction 539 performs ramping, channeling, peripheral and plunging cuts
- Engineered for stability over a broad range of applications