



CCMT 21.51 Z14

APPLICATION

- Generic grade for steel
- Suitable for fine to heavy machining of steels, stainless-steels and cast-irons



GRADE Z14

This is a TIN PVD coated carbide insert for fine to heavy machining of steels, stainless-steels and cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30	N30		
Sfm ft/min	492 - 738	295 - 443	459 - 689	738 - 2575		
Fn Inch/Z	0.0031 - 0.0079	0.0035 - 0.0071	0.0031 - 0.0079	0.0031 - 0.0094		
ap Inch	0.012 - 0.059	0.012 - 0.059	0.012 - 0.059	0.012 - 0.059		

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

$S \text{ (RPM)} = Sfm * 12 / \pi / D = \text{rev per minute}$
$F \text{ (IPR, inch per revolution)} = S * Fn = \text{feed per minute}$
$F \text{ (IPM, inch per minute)} = S * Fz * n.\text{flutes} = \text{feed per minute}$
$Sfm = S * D * \pi / 12$