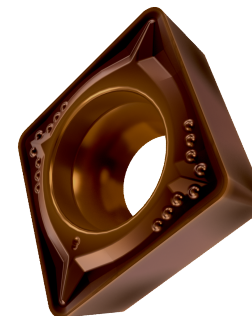


CCMT.FM 21.51 Z5P



APPLICATION

- Suitable for fine to medium machining of steels and stainless-steels
- Continuous and interrupted cut



GRADE Z5P

It is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20 - M35	K25 - K40	N25 - N40		
Sfm ft/min	574 - 951	312 - 509	459 - 771	787 - 3035		
Fn Inch/rev	.003 - .008	.004 - .007	.003 - .008	.003 - .009		
ap Inch	.012 - .059	.012 - .059	.012 - .059	.012 - .059		

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT