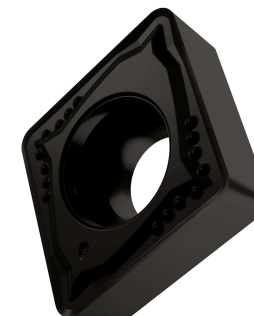


CCMT.FM 32.51 Z12



APPLICATION

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



GRADE Z5P

It is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05-P25, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P05 - P25		K05 - K25			
Sfm ft/min	656 - 935		623 - 886			
Fn Inch/rev	.006 - .010		.006 - .010			
ap Inch	.012 - .118		.012 - .118			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT