

# DCMT.FM 21.50 Z9



## APPLICATION

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



## GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35	M10-M30	K15 - K35			
Sfm ft/min	738 - 1001	443 - 591	689 - 935			
Fn Inch/rev	.003 - .004	.003 - .004	.003 - .004			
ap Inch	.008 - .039	.008 - .039	.008 - .039			

### 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**