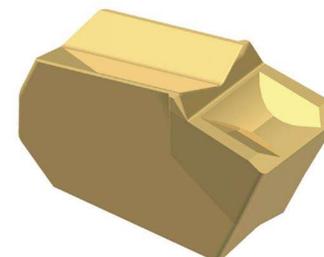




GTR 5 Z7

APPLICATION

- Suitable for machining steel and stainless steel
- 8° front angle to reduce pip and burr on the right hand side,



GRADE Z7

This PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 -P40 and K20 -K40 for machining of steel and stainless steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30			
Sfm ft/min	230 - 427	131 - 246	213 - 394			
Fn Inch/Z	0.0028 - 0.0079	0.003 - 0.0071	0.0028 - 0.0079			
ap Inch						

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution) = S * Fn= feed per minute
F (IPM, inch per minute) = S * Fz * n.flutes= feed per minute
Sfm = S * D * π / 12