



# APKT.PM 1604 Z5



## APPLICATION

- Suitable for steel and stainless steel, also without coolant
- It is an excellent grade for unstable cutting conditions with low up to medium cutting speed.

## GRADE Z5

This is a PVD TiAlN coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and stainless steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30 - P50	M30 - M40				
<b>Sfm ft/min</b>	930 - 645	575 - 388				
<b>Fn Inch/Z</b>	.010 - .017	.010 - .016				
<b>ap Inch</b>	.031 - .512	.031 - .386				

### LEGEND

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

### FORMULA

**S (RPM)** =  $Sfm * 12 / \pi / D$  = 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** =  $S * D * \pi / 12$

**MILLING CARBIDE INSERT**