



Z16ER A60 Z5

APPLICATION

- Suitable for threading operations
- Single-sided lay down carbide insert Tin Coated



GRADE Z5

This is a PVD tialn coated fine grained WC-Co carbide within ISO-grade ranges P25-P40/M20-M35 and K20-K40 for machining of steel and stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30				
Sfm ft/min	443 - 525	262 - 312				
Fn Inch/Z						
ap Inch						

LEGEND

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

FORMULA

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