

# ADKT 1505 Z5

## APPLICATION

- Suitable for steel on manual milling machine

## GRADE Z5

This grade has a substrate without cubical carbides with a multi-layered nanostructural coating with high content of Al applied by PVD method. This superlative grade combines good wear resistance and good operation reliability. It is a general purpose grade for all groups of works material. This grade is perfect for less favourable cutting conditions with medium cutting speed.



	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15-P35	M15-M35	K15-K35			
Sfm ft/min	722-459	426-262	672-426			
Fn Inch/rev	.006-.012	.006-.009	.006-.012			
ap Inch	.039-.512	.039-.386	.039-.512			

### LEGEND

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

### FORMULA

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

