



# CCMT 21.51 ZC2

## APPLICATION

- Suggested for finishing operations with high feed rate
- Suitable for fine to heavy machining of steels



## GRADE ZC2

This is an uncoated cermet insert within ISO range P10-P25, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P20	M20				
<b>Sfm ft/min</b>	623 - 1017	361 - 607				
<b>Fn Inch/Z</b>	0.0031 - 0.0102	0.0035 - 0.0092				
<b>ap Inch</b>	0.016 - 0.079	0.016 - 0.079				

### LEGEND

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

### FORMULA

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

