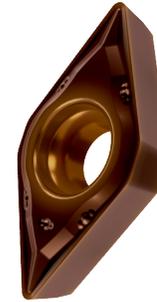


# DCMT.FM 21.50 Z5P



## APPLICATION

- Suitable for fine to medium machining of steels and stainless-steels
- Continuous and interrupted cut



## GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20-M35	K25 - K40	N25 - N40		
Sfm ft/min	591 - 902	312 - 492	476 - 738	804 - 2871		
Fn Inch/rev	.002 - .004	.003 - .004	.002 - .004	.002 - .005		
ap Inch	.008 - .039	.008 - .039	.008 - .039	.008 - .039		

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**