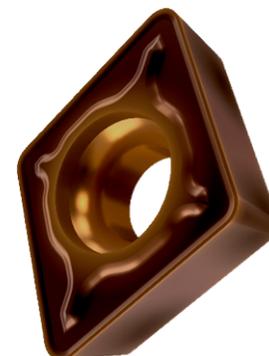




ECMT.FM2 21.51 Z5P

APPLICATION

- Suitable for fine to medium machining of steels
- Used on drilling bodies 851



GRADE Z5P

This is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M25	K30			
Sfm ft/min	443 - 984	246 - 541	361 - 804			
Fn Inch/Z	0.002 - 0.0098	0.0022 - 0.0089	0.002 - 0.0098			
ap Inch	0.012 - 0.106`	0.012 - 0.106	0.012 - 0.106			

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