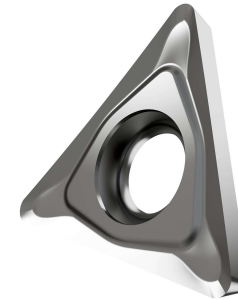




TCGT 21.51 ZK5

APPLICATION

- Suitable for fine to heavy machining of non-ferrous metals
- Continuous and interrupted cut



GRADE ZK5

This grade is a PVD coated fine grained WC-Co carbide within ISO range N05 - N20, for fine to heavy machining of non-ferrous metals

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				N05 - N20		
Sfm ft/min				640 - 2231		
Fn Inch/rev				.004 - .009		
ap Inch				.016 - .143		

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT