



ADLX 1503 Z5

APPLICATION

- Suitable for steel and super alloy, also without coolant

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	P25-P50					
Sfm ft/min	920-655					
Fn Inch/Z	.004-.010					
ap Inch	.039-.354					

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT