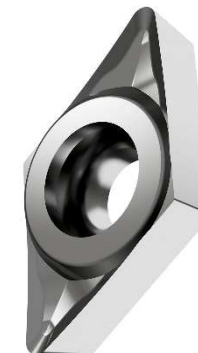




DCGT 21.51 ZKX



APPLICATION

- Suitable for fine to heavy machining of non-ferrous metals
- Positive polished uncoated insert

GRADE ZKX

This is an uncoated fine grained WC-Co carbide within ISO range N10 - N25, for fine to heavy machining of non-ferrous metals

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				N10 - N25		
Sfm ft/min				443 - 1493		
Fn Inch/Z				0.0039 - 0.0094		
ap Inch				0.016 - 0.083		

LEGEND

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

FORMULA

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