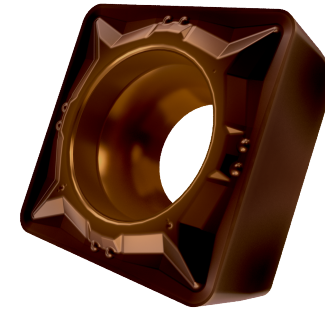


SCMT.FM 32.51 Z5P



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	541 - 853	295 - 459	443 - 705	738 - 2756		
Fn Inch/rev	.004 - .009	.004 - .008	.004 - .009	.004 - .010		
ap Inch	.012 - .118	.012 - .118	.012 - .118	.012 - .118		

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution) = S * Fn= feed per minute
F (IPM, inch per minute) = S * Fz * n.flutes= feed per minute
Sfm = S * D * π / 12

TURNING CARBIDE INSERT