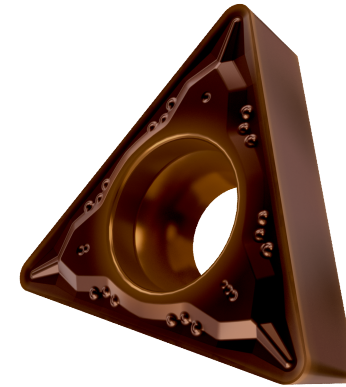




TCMT.FM 32.51 Z5P

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	K15 - K35	N25 - N40		
Sfm ft/min	443 - 689	246 - 377	361 - 574	607 - 2231		
Fn Inch/rev	.004 - .008	.004 - .007	.004 - .008	.004 - .009		
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

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

TURNING CARBIDE INSERT