



DCMT.FM 21.52 Z9

APPLICATION

- Suitable for fine to medium machining of steels and stainless-steels
- Continuous and interrupted cut



GRADE Z9

It is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25		K25			
Sfm ft/min	525 - 1099		492 - 1033			
Fn Inch/Z	0.0024 - 0.0098		0.0024 - 0.0098			
ap Inch	0.024 - 0.079		0.024 - 0.079			

LEGEND

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

FORMULA

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

TURNING INSERT