



DCGT 21.50 ZK5



APPLICATION

- Suitable for fine to heavy machining of non-ferrous metals
- Positive polished and pvd coated inserts

GRADE ZK5

This is a PVD coated fine grained WC-Co carbide within ISO range N05 - N20, for fine to heavy machining of non-ferrous metals

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				K10		
Sfm ft/min				787 - 2526		
Fn Inch/Z				.002 - .005		
ap Inch				.012 - .083		

LEGEND

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

FORMULA

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