



CCGT 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				N05 - N20		
Sfm ft/min				853 - 3100		
Fn Inch/Z				0.0024 - 0.0061		
ap Inch				0.012 - 0.118		

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