



# CCGT 21.51 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
<b>GROUP</b>				N05 - N20		
<b>Sfm ft/min</b>				656 - 2641		
<b>Fn Inch/Z</b>				0.0039 - 0.0123		
<b>ap Inch</b>				0.016 - 0.138		

### LEGEND

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

### FORMULA

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