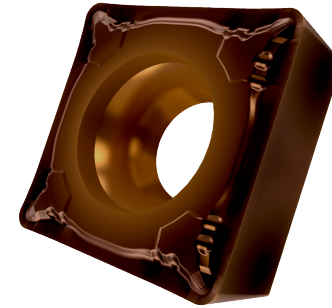




SCMT.UR 433 Z5P

APPLICATION

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



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M25 - M40	K25 -K40			
Sfm ft/min	410 - 951	213 - 509	328 - 771			
Fn Inch/rev	.003 - .020	.004 - .018	.003 - .020			
ap Inch	.047 - .157	.047 - .157	.047 - .157			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT