

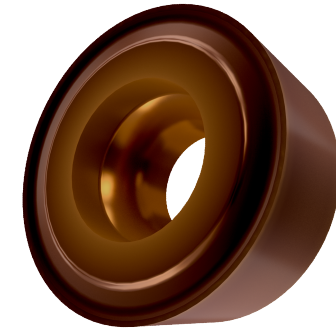
# RCMT.UR 0803MOE Z5P



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

## APPLICATION

## 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
<b>GROUP</b>	P25 - P40	M25 - M40	K25 -K40			
<b>Sfm ft/min</b>	476 - 951	262 - 509	394 - 771			
<b>Fn Inch/rev</b>	.005 - .020	.006 - .018	.005 - .020			
<b>ap Inch</b>	.013 - .118	.013 - .118	.013 - .118			

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**