



# GTR 3 Z7

## APPLICATION

- Suitable for machining steel and stainless steel
- 8° front angle to reduce pip and burr on the right hand side,



## GRADE Z7

This PVD coated fine grained WC-Co carbide within ISO-grade ranges P25 -P40 and K20 -K40 for machining of steel and stainless steel.

|            | STEEL           | STAINLESS      | CAST IRON       | NON FERROUS | S.ALLOYS | HEAT TREATED |
|------------|-----------------|----------------|-----------------|-------------|----------|--------------|
| GROUP      | P35             | M35            | K30             |             |          |              |
| Sfm ft/min | 230 - 427       | 131 - 246      | 213 - 394       |             |          |              |
| Fn Inch/Z  | 0.0028 - 0.0063 | 0.003 - 0.0057 | 0.0028 - 0.0063 |             |          |              |
| ap Inch    |                 |                |                 |             |          |              |

### LEGEND

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

### FORMULA

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