



# GFN.X 3 Z7

## APPLICATION

- Suitable for machining steel and stainless steel
- 0° front angle for grooving and parting off with chipbreaker



## GRADE Z7

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30			
Sfm ft/min	230 - 427	131 - 246	213 - 394			
Fn Inch/Z	0.002 - 0.0067	0.0022 - 0.006	0.002 - 0.0067			
ap Inch						

### 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> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn= feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes= feed per minute
<b>Sfm</b> = S * D * π / 12