



CCMT 32.52 Z14

APPLICATION

- Generic grade for steel
- Suitable for fine to heavy machining of steels, stainless-steels and cast-irons



GRADE Z14

This is a TIN PVD coated carbide insert for fine to heavy machining of steels, stainless-steels and cast-irons

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|------------|-----------------|-----------------|-----------------|-------------|----------|--------------|
| GROUP | P30 | M30 | K30 | | | |
| Sfm ft/min | 361 - 705 | 213 - 410 | 328 - 656 | | | |
| Fn Inch/Z | 0.0031 - 0.0197 | 0.0035 - 0.0177 | 0.0031 - 0.0197 | | | |
| ap Inch | 0.031 - 0.118 | 0.031 - 0.118 | 0.031 - 0.118 | | | |

LEGEND

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

FORMULA

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