



# CCMT 432 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
<b>GROUP</b>	P30	M30	K30			
<b>Sfm ft/min</b>	344 - 689	197 - 410	312 - 640			
<b>Fn Inch/Z</b>	0.0031 - 0.0197	0.0035 - 0.0177	0.0031 - 0.0197			
<b>ap Inch</b>	0.031 - 0.157	0.031 - 0.157	0.031 - 0.157			

### LEGEND

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

### FORMULA

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