



TPMR .47 221 Z9

APPLICATION

- Single-sided positive turning insert with chipbreaker
- Suggested to use on manual lather for machining of steels



GRADE Z9

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P15 - P35, for medium to fine machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25	M25	K25			
Sfm ft/min	443 - 558	262 - 328	410 - 525			
Fn Inch/Z	0.0059 - 0.0079	0.0065 - 0.0071	0.0059 - 0.0079			
ap Inch	0.031 - 0.157	0.031 - 0.157	0.031 - 0.157			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT