

TPMR.47 322 Z7



APPLICATION

- Suitable for fine to medium machining of steels
- Continuous and interrupted cut



GRADE Z7

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P20-P45, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20 - P45	M20 - M45				
Sfm ft/min	328 - 574	197 - 344				
Fn Inch/rev	.006 - .016	.007 - .014				
ap Inch	.031 - .157	.031 - .157				

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT