



VBMT.UR 331 Z9

APPLICATION

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

GRADE Z9

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



	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35	M15 - M35	K15 - K35			
Sfm ft/min	427 - 558	246 - 328	394 - 525			
Fn Inch/rev	.006 - .008	.006 - .007	.006 - .008			
ap Inch	.016 - .079	.016 - .079	.016 - .079			

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