



CNMG.78 431L Z5P

APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels



GRADE Z5P

It is PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for medium to heavy machining of steels and stainless-steels with a left handed turning tool

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30		N30	S30	
Sfm ft/min	591 - 787	312 - 427		804 - 2526	98 - 197	
Fn Inch/rev	.007 - .010	.007 - .009		.006 - .012	.007 - .009	
ap Inch	.031 - .197	.031 - .197		.031 - .197	.031 - .197	

LEGEND

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

FORMULA

S (RPM)	= Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution)	= S * Fn = feed per minute
F (IPM, inch per minute)	= S * Fz * n.flutes = feed per minute
Sfm	= S * D * π / 12

TURNING CARBIDE INSERT