



# CNMG.78 431L Z9

## APPLICATION

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



## GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30, 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
<b>GROUP</b>	P25	M30			S25	
<b>Sfm ft/min</b>	705 - 968	410 - 574			115 - 246	
<b>Fn Inch/rev</b>	.007 - .010	.007 - .009			.007 - .009	
<b>ap Inch</b>	.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

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