



CNMG.78 432L Z9

APPLICATION

- Suitable for steel and stainless steel and super alloy



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
GROUP	P25	M30			S25	
Sfm ft/min	640 - 1066	377 - 640			115 - 279	
Fn Inch/rev	.008 - .019	.008 - .017			.009 - .014	
ap Inch	.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

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