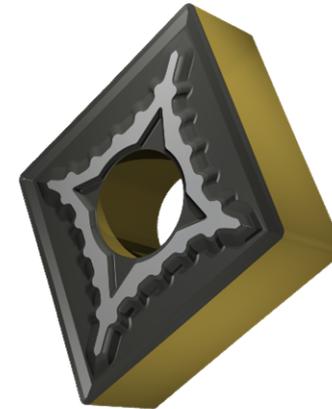


CNMG.SM 542 Z15



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



GRADE Z15

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05 - P30, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K20			H10
Sfm ft/min	656 - 1099		623 - 1033			131 - 213
Fn Inch/rev	.006 - .020		.006 - .020			.004 - .010
ap Inch	.031 - .276		.031 - .276			.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT