



# CNMG.M 643 Z9

## APPLICATION

- Suitable for fine to heavy machining of steels
- Interrupted and continuous cut



## GRADE Z9

This 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
<b>GROUP</b>	P25		K20			
<b>Sfm ft/min</b>	427 - 919		394 - 869			
<b>Fn Inch/rev</b>	.007 - .030		.007 - .030			
<b>ap Inch</b>	.047 - .315		.047 - .315			

### LEGEND

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

### FORMULA

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