



CNMG.RM 432 Z12

APPLICATION

- Suitable for medium to heavy machining of steels
- Continuous cutting conditions



GRADE Z12

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05-P25

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P05-P25		K05-K25			
Sfm ft/min	623 - 1050		591 - 984			
Fn Inch/rev	.008 - .020		.008 - .020			
ap Inch	.039 - .276		.039 - .276			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT