



CNMG.RM 544 Z7

APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels
- Interrupted cutting conditions



GRADE Z7

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P20-P45, for medium to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20 - P45	M15-M40			S20-S45	
Sfm ft/min	427 - 738	246 - 443			66 - 197	
Fn Inch/rev	.012 - .032	.013 - .028			.013 - .022	
ap Inch	.079 - .315	.079 - .315			.079 - .252	

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