

# CNMG.SM 432 Z9



- Suitable for fine to heavy machining of steels and stainless-steels
- Continuous and interrupted cut

## APPLICATION



## GRADE Z9

This is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15 - P35 and M10 - M30, for fine to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25-P40	M20-M35	K25 - K40		S25 - S40	
Sfm ft/min	427 - 902	246 - 541	394 - 853		66 - 230	
Fn Inch/rev	.008 - .018	.009 - .016	.008 - .018		.008 - .014	
ap Inch	.031 - .157	.031 - .157	.031 - .157		.031 - .026	

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**