

CNMP 431 Z14



- Suitable for generic application on steel and stainless steel
- Suggested for continuous cut



GRADE Z14

Z14 is a MT-CVD coated WC-Co carbide within ISO ranges P20 - P40 and K25 - K40, for medium to heavy machining of steels and stainless steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30			S30	
Sfm ft/min	574 - 984	344 - 591			115 - 295	
Fn Inch/rev	.008 - .020	.009 - .017			.008 - .014	
ap Inch	.031 - .197	.031 - .197			.013 - .157	

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