



SNMM .81 432 Z14

APPLICATION

- Monolateral negative turning insert
- Suitable for medium to extra heavy machining of steels



GRADE Z14

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35	K35		S30	
Sfm ft/min	476 - 607	279 - 361	443 - 574		82 - 180	
Fn Inch/Z	0.0118 - 0.0173	0.013 - 0.0156	0.0118 - 0.0173		0.0118 - 0.0139	
ap Inch	0.031 - 0.276	0.031 - 0.276	0.031 - 0.276		0.031 - 0.22	

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

