



SNMM .81 433 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	443 - 623	262 - 361	410 - 591		82 - 180	
Fn Inch/Z	0.0126 - 0.026	0.0139 - 0.0234	0.0126 - 0.026		0.0139 - 0.0208	
ap Inch	0.047 - 0.295	0.047 - 0.295	0.047 - 0.295		0.047 - 0.236	

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

