



# SNMM .81 433 Z9



## APPLICATION

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

## GRADE Z9

This is a a MT-CVD coated functionally graded WC-Co carbide within ISO range P15 - P35, for medium to extra heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25	M25	K25		S25	
Sfm ft/min	525 - 804	312 - 476	492 - 755		82 - 213	
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

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

# TURNING CARBIDE INSERT

