



SNMM .81 542 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	591 - 722	344 - 427	558 - 673		98 - 180	
Fn Inch/Z	0.0138 - 0.0173	0.0138 - 0.0156	0.0138 - 0.0173		0.0138 - 0.0156	
ap Inch	0.079 - 0.315	0.079 - 0.315	0.079 - 0.315		0.079 - 0.252	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT

