



SNMM .81 643 Z14

APPLICATION

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



GRADE Z14

This is a a MT-CVD TIN coated functionally graded WC-Co carbide within ISO range P30 - P40, 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	509 - 771	295 - 459	476 - 722		82 - 197	
Fn Inch/Z	0.0126 - 0.026	0.0139 - 0.0234	0.0126 - 0.026		0.0139 - 0.0208	
ap Inch	0.059 - 0.472	0.059 - 0.472	0.059 - 0.472		0.059 - 0.378	

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