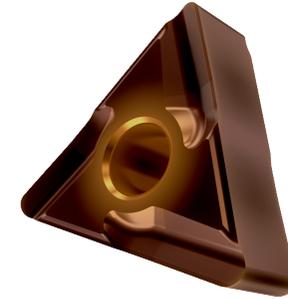


TNMG.78 332L Z5P



APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels with a left handed turning tool
- Continuous and interrupted cut



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for medium to heavy machining of steels and stainless-steels with a left handed turning tool

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20 - M35		N25 - N40	S25 - S40	
Sfm ft/min	476 - 738	262 - 394		656 - 2346	82 - 180	
Fn Inch/rev	.008 - .016	.009 - .014		.008 - .019	.009 - .011	
ap Inch	.031 - .197	.031 - .197		.031 - .197	.031 - .157	

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution) = S * Fn = feed per minute
F (IPM, inch per minute) = S * Fz * n.flutes = feed per minute
Sfm = S * D * π / 12

TURNING CARBIDE INSERT