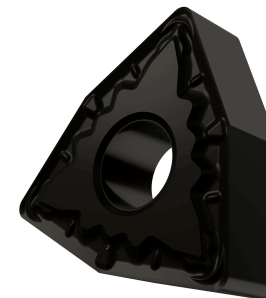


WNMG.FM 331 Z9



APPLICATION

- Suitable for fine to medium machining of steels
- Continuous and interrupted cut



GRADE Z9

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35	M15 - M35	K15 - K35		S15 - S35	
Sfm ft/min	656 - 935	394 - 558	623 - 886		115 - 246	
Fn Inch/rev	.006 - .010	.007 - .009	.006 - .010		.006 - .008	
ap Inch	.02 - .118	.02 - .118	.02 - .118		.02 - .094	

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