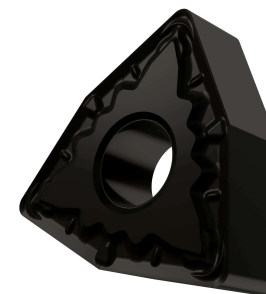


# WNMG.FM 332 Z9



## 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  | 673 - 1099  | 394 - 656   | 623 - 1033  |             | 115 - 295   |              |
| Fn Inch/rev | .006 - .014 | .007 - .012 | .006 - .014 |             | .006 - .011 |              |
| ap Inch     | .031 - .118 | .031 - .118 | .031 - .118 |             | .031 - .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**