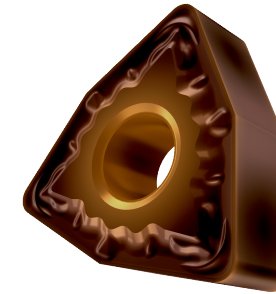




WNMG.FM 431 Z5P

APPLICATION

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



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M25 - M40	K25 - K40		S25 - S40	
Sfm ft/min	509 - 919	279 - 492	427 - 755		82 - 230	
Fn Inch/rev	.004 - .010	.004 - .009	.004 - .010		.004 - .007	
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 (RPM) = $Sfm * 12 / \pi / D$ = 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 = $S * D * \pi / 12$

TURNING CARBIDE INSERT