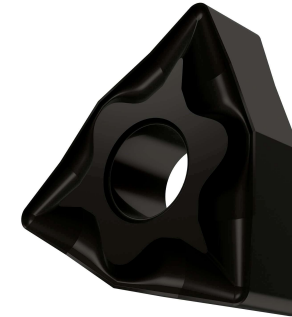


WNMG.NF 432 Z9



APPLICATION

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



GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35	M10 - M30	K15 - K35		S15 - S35	
Sfm ft/min	558 - 1083	328 - 640	525 - 1017		98 - 279	
Fn Inch/rev	.006 - .014	.007 - .012	.006 - .014		.006 - .011	
ap Inch	.031 - .138	.031 - .138	.031 - .138		.031 - .11	

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