



SNMG.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	574 - 1148	344 - 689	541 - 1083		98 - 295	
Fn Inch/rev	.006 - .014	.007 - .013	.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 (RPM)	$S = \frac{Sfm * 12}{\pi * D}$ = rev per minute
F (IPR, inch per revolution)	$F = S * Fn$ = feed per minute
F (IPM, inch per minute)	$F = S * Fz * n.flutes$ = feed per minute
Sfm	$Sfm = S * D * \pi / 12$

TURNING CARBIDE INSERT