

SNMG.RM 644 Z9



APPLICATION

- Suitable for fine to heavy 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 heavy 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	443 - 853	262 - 509	410 - 804		66 - 230	
Fn Inch/rev	.012 - .022	.013 - .020	.012 - .022		.012 - .017	
ap Inch	.063 - .236	.063 - .236	.063 - .236		.063 - .189	

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

S (RPM)	$Sfm * 12 / \pi / D = \text{rev per minute}$
F (IPR, inch per revolution)	$S * Fn = \text{feed per minute}$
F (IPM, inch per minute)	$S * Fz * n.\text{flutes} = \text{feed per minute}$
Sfm	$S * D * \pi / 12$

TURNING CARBIDE INSERT