

CNMG.RM 433 Z7



APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels
- Interrupted cutting conditions



GRADE Z7

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P20-P45, for medium to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20-P45	M20-M45			S20-S45	
Sfm ft/min	443 - 787	262 - 459			66 - 197	
Fn Inch/rev	.010 - .028	.011 - .025			.011 - .020	
ap Inch	.059 - .276	.059 - .276			.059 - .22	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT