



CNMG.RM 643 Z9

APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels
- Interrupted and continuous cut



GRADE Z9

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P15-P35, for medium 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	509 - 886	295 - 525	476 - 837		82 - 230	
Fn Inch/rev	.010 - .028	.011 - .025	.010 - .028		.011 - .019	
ap Inch	.059 - .394	.059 - .394	.059 - .394		.059 - .315	

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 / π / 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 * π / 12

TURNING CARBIDE INSERT