



# CNMG.RM 644 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 |
|--------------------|-------------|-------------|-------------|-------------|-------------|--------------|
| <b>GROUP</b>       | P15-P35     | M10-M30     | K15-K35     |             | S15 - S35   |              |
| <b>Sfm ft/min</b>  | 492 - 837   | 295 - 492   | 459 - 787   |             | 82 - 213    |              |
| <b>Fn Inch/rev</b> | .012 - .032 | .013 - .028 | .012- .032  |             | .013 - .022 |              |
| <b>ap Inch</b>     | .079 - .394 | .079 - .394 | .079 - .394 |             | .079 - .315 |              |

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**