

CNMG.SF 431 Z9



- Suitable for fine to medium machining of steels and stainless-steels

- Continuous and interrupted cut

APPLICATION



GRADE Z9

This 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	443 - 902	262 - 541	410 - 853		66 - 230	
Fn Inch/rev	.006 - .010	.006 - .009	.006 - .010		.006 - .009	
ap Inch	.016 - .106	.016 - .106	.016 - .106		.016 - .085	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT