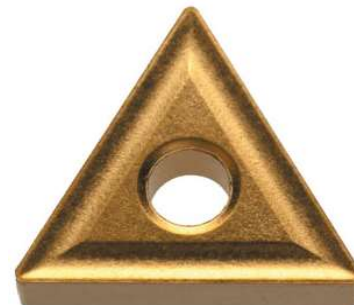




TNMG 542 Z14

APPLICATION

- Generic grade for steel
- Suitable for fine machining of steels and cast-irons



GRADE Z14

This is a TIN PVD coated carbide insert for fine machining of steels and cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30				
Sfm ft/min	361 - 509	213 - 295				
Fn Inch/Z	0.0079 - 0.0157	0.0087 - 0.0142				
ap Inch	0.031 - 0.236	0.031 - 0.236				

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