

# TNMG.RM 433 Z7



## APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels
- Continuous and interrupted cut



## GRADE Z7

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P20 - P45 and M15 - M40, for medium to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P20 - P45	M15 - M40			S20 - S45	
<b>Sfm ft/min</b>	410 - 673	246 - 394			66 - 180	
<b>Fn Inch/rev</b>	.010 - .024	.011 - .022			.011 - .017	
<b>ap Inch</b>	.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

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

**TURNING CARBIDE INSERT**