



RCMX 1003MOS Z7

APPLICATION

- Special design positive turning insert, round with 7° clearance,
- Suitable for heavy to medium machining of steels



GRADE Z7

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P20-P45, for heavy to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30				
Sfm ft/min	344 - 558	197 - 328				
Fn Inch/Z	0.0157 - 0.0394	0.0173 - 0.0354				
ap Inch	0.059 - 0.098	0.059 - 0.098				

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