

CNMG.SM 431 Z9



- Suitable for fine to heavy 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 heavy 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	459 - 804	262 - 476	427 - 755		82 - 213	
Fn Inch/rev	.007 - .010	.007 - .009	.007 - .010		.007 - .009	
ap Inch	.016 - .157	.016 - .157	.016 - .157		.016 - .026	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT