



GPN.R 3 Zi9

APPLICATION

- Double ended parting and grooving insert
- The .R geometry with negative T-land, first choice for difficult grooving and parting-off, and continuous to interrupted cuts.



GRADE Zi9

This T7325 MT-CVD coated functionally graded WC-Co carbide within ISO-grade range K15 -K25 for machining of cast-iron.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20	M20	K20			
Sfm ft/min	295 - 492	230 - 377	279 - 459			
Fn Inch/Z	0.002 - 0.0079	0.0024 - 0.0071	0.002 - 0.0079			
ap Inch						

LEGEND

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

FORMULA

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

CUT-OFF CARBIDE INSERT