



GPN.M 4 Zi9

APPLICATION

- Double ended parting and grooving insert
- The .M geometry with highly positive rake, first choice for parting-off, and continuous to slightly interrupted cuts



GRADE Zi9

This MT-CVD coated functionally graded WC-Co carbide within ISO-grade range M10 -M25 for machining of stainless-steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20	M20	K20		S15	
Sfm ft/min	295 - 492	230 - 377	279 - 459		66 - 180	
Fn Inch/Z	0.0031 - 0.0071	0.0035 - 0.0063	0.0031 - 0.0071		0.0035 - 0.0055	
ap Inch						

LEGEND

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

FORMULA

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

CUT-OFF CARBIDE INSERT