

VNMG.SF 332 Z5P



APPLICATION

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



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20- M35	K25 - K40	N25 - N40	S25 - S40	H25 - H40
Sfm ft/min	295 - 656	164 - 361	246 - 541	410 - 2116	49 - 164	49 - 115
Fn Inch/rev	.005 - .010	.005 - .009	.005 - .010	.005 - .012	.005 - .008	.004 - .006
ap Inch	.031 - .098	.031 - .098	.031 - .098	.031 - .098	.031 - .079	.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT