



CNMG.RM 432 Zi9

APPLICATION

- Suitable for medium to heavy machining of stainless-steels
- Continuous cutting conditions



GRADE Zi9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges M25, for medium to heavy machining of stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10-P25	M10-M25			S10-S25	
Sfm ft/min	509 - 755	394 - 574			131 - 279	
Fn Inch/rev	.008 - .020	.0087 - .0177			.009 - .014	
ap Inch	.039 - .276	.039 - .276			.039 - .22	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT