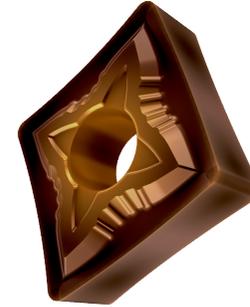


CNMG.SF 432 Z5P



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 range P25-P40, 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	410 - 935	213 - 509	328 - 755	558 - 2986	66 - 230	66 - 148
Fn Inch/rev	.005 - .012	.005 - .010	.005 - .012	.005 - .014	.005 - .008	.004 - .006
ap Inch	.031 - .118	.031 - .118	.031 - .118	.031 - .118	.031 - .094	.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT