

# CNMG.SM 432 Zi9



- Suitable for fine to heavy machining of stainless-steels and super-alloys
- Continuous and interrupted cut

## APPLICATION



## GRADE Zi9

This is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges M10-M25 and S10-S25, for fine to heavy machining of stainless-steels and super-alloys

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P25-P40	M10-M25			S10-S25	
<b>Sfm ft/min</b>	394 - 738	295 - 574			98 - 279	
<b>Fn Inch/rev</b>	.008 - .018	.009 - .016			.008 - .014	
<b>ap Inch</b>	.031 - .157	.031 - .157			.031 - .026	

### LEGEND

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

### FORMULA

<b>S (RPM)</b>	= Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b>	= S * Fn= feed per minute
<b>F (IPM, inch per minute)</b>	= S * Fz * n.flutes= feed per minute
<b>Sfm</b>	= S * D * π / 12

**TURNING CARBIDE INSERT**