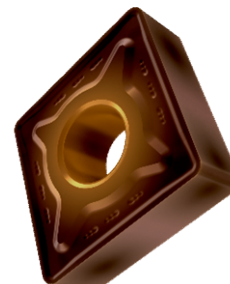


CNMG.RM 432 Z5P



APPLICATION

- Suitable for medium to heavy machining of steels
- Interrupted and continuous cutting conditions



GRADE Z5P

This is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for medium to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25-P40	M25-M40	K25-K40		S25-S40	
Sfm ft/min	459 - 771	246 - 410	377 - 623		66 - 197	
Fn Inch/rev	.008 - .020	.009 - .018	.008 - .020		.009 - .014	
ap Inch	.039 - .276	.039 - .276	.039 - .276		.039 - 0.22	

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