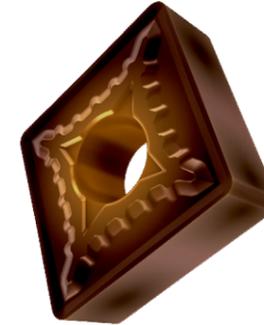


CNMG.SM 431 Z5P



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	377 - 656	197 - 361	295 - 541	509 - 2116	49 - 164	49 - 115
Fn Inch/rev	.007 - .010	.007 - .009	.007 - .010	.007 - .012	.007 - .009	.005 - .007
ap Inch	.016 - .157	.016 - .157	.016 - .157	.016 - .157	.016 - .026	.008 - .02

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT