

CNMG.SM 432 Zi7



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

APPLICATION



GRADE Zi7

This is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges M20-M40 and S15-S25, for fine to heavy machining of stainless-steels and super-alloys

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------|-------------|-------------|-----------|-------------|-------------|--------------|
| GROUP | P25-P40 | M20-M40 | | | S15-S25 | |
| Sfm ft/min | 361 - 705 | 279 - 541 | | | 82 - 262 | |
| Fn Inch/rev | .008 - .018 | .009 - .016 | | | .008 - .014 | |
| ap Inch | .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

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

TURNING CARBIDE INSERT