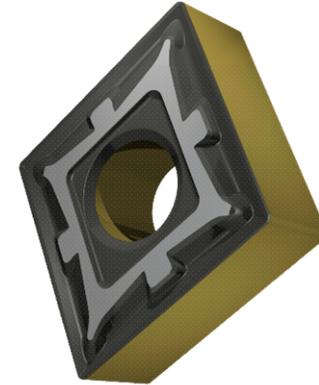


CNMG.M 432 Z15



APPLICATION

- Suitable for fine to heavy machining of steels
- Continuous cut



GRADE Z15

a MT-CVD coated functionally graded WC-Co carbide within ISO range P05 - P30, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K15			H10
Sfm ft/min	722 - 935		673 - 886			113 - 180
Fn Inch/rev	.007 - .010		.007 - .010			.004 - .007
ap Inch	.031 - .236		.031 - .236			.008 - .020

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT