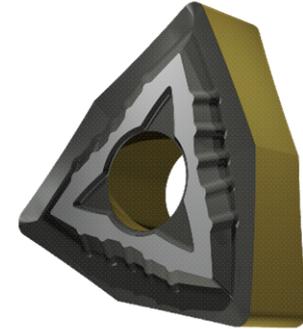


WNMG.SF 432 Z15



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



APPLICATION

GRADE Z15

This is 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	P05 - P30		K05 - K30			H15
Sfm ft/min	640 - 1296		607 - 1230			115 - 246
Fn Inch/rev	.006 - .012		.006 - .012			.004 - .008
ap Inch	.031 - .118		.031 - .118			.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT