

CNMG.RM 642 Z9



APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels
- Interrupted and continuous cut



GRADE Z9

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P15-P35, for medium to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15-P35	M10-M30	K15-K35		S15 - S35	
Sfm ft/min	541 - 919	312 - 541	509 - 869		82 - 246	
Fn Inch/rev	.008 - .028	.008 - .017	.008 - .020		.009 - .014	
ap Inch	.039 - .394	.039 - .394	.039 - .394		.039 - .315	

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