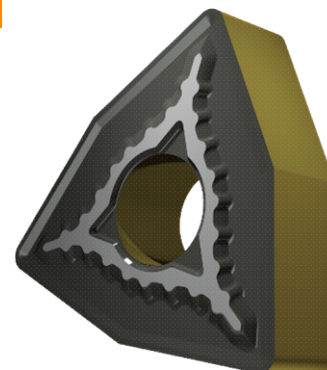




WNMG.SM 432 Z15

APPLICATION

- Suitable for fine to medium machining of steels
- Continuous cutting conditions



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		K20			H10
Sfm ft/min	574 - 1148		541 - 1083			115 - 230
Fn Inch/Z	0.0079 - 0.0177		0.0079 - 0.0177			0.0047 - 0.0091
ap Inch	0.031 - 0.157		0.031 - 0.157			0.016 - 0.039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT