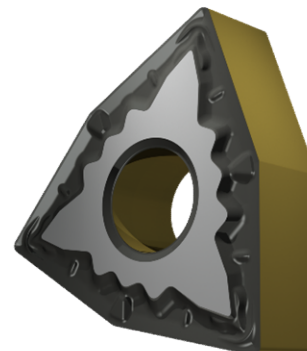




WNMG.FM 431 Z15

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 medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P05-P30		K20			
Sfm ft/min	837 - 1165		787 - 1099			
Fn Inch/Z	0.0059 - 0.0102		0.0059 - 0.0102			
ap Inch	0.02 - 0.118		0.02 - 0.118			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT