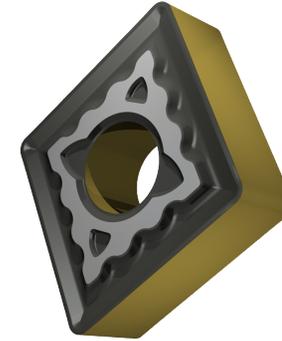


# CNMG.M 432 Z16



- Suitable for fine to heavy machining of cast irons

- continuous cut



## APPLICATION

## GRADE Z16

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05 - P30, for medium machining of cast irons. It features slightly positive rake angle and stable, wide T-land.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P15		K20			H10
<b>Sfm ft/min</b>	705 - 1132		705 - 1132			148 - 230
<b>Fn Inch/rev</b>	.006 - .018		.006 - .018			.006 - .012
<b>ap Inch</b>	.031 - .177		.031 - .177			.016 - .047

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**