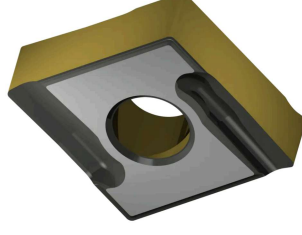




CNMG.78 431R Z25



Double-sided Negative turning insert the first choice for finishing of Steels and Cast irons. also conditionally suitable for Stainless steels and Super-alloys. is suitable for materials and Continuous cut.

GRADE Z25

This grade is versatile and is the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials. and MT-CVD-coated, functionally graded substrate Z25, designed primarily for P-group materials. is suitable for materials: P - Steel and cast steel (steels with alloy content ≤ 10% and a hardness of < 45HRC), K - Cast Iron (castings of iron and carbon alloys with > 2% carbon content) and Slightly interrupted cut.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S-ALLOYS	HEAT TREATED
GROUP	P30	M30	K30		S30	
sfm ft/min	1017 - 1378	607 - 820	951 - 1296		180 - 361	
Fn inch/Z	0.0059 - 0.0102	0.0065 - 0.0092	0.0059 - 0.0102		0.0059 - 0.0082	
ap inch	0.02 - 0.118	0.02 - 0.118	0.02 - 0.118		0.02 - 0.094	

LEGENDA

sfm (Vc) Surface per minute
Fn (ipr) Feed per revolution
Fz (ipt) Feed per tooth
ap Depth per cut

FORMULA

S (RPM) = $V_c * 1000 / \pi / D$ = rev per minute
F (IPR, inch per revolution) = $S * F_n$ = feed per minute
F (IPM, inch/per minute) = $S * F_z * n$.flutes= feed per minute
sfm = $S * D * \pi / 1000$

TURNING CARBIDE INSERT