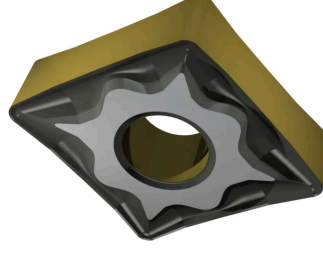




CNMG.NF 432 Z25



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 $\leq 10\%$ and a hardness of $< 45\text{HRC}$), 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	869 - 1608	509 - 951	820 - 1526		148 - 427	
Fn inch/Z	0.0059 - 0.0138	0.0065 - 0.0124	0.0059 - 0.0138		0.0059 - 0.011	
ap inch	0.031 - 0.138	0.031 - 0.138	0.031 - 0.138		0.031 - 0.11	

LEGENDA

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

FORMULA

$S \text{ (RPM)} = Vc * 1000 / \pi / D = \text{rev per minute}$
 $F \text{ (IPR, inch per revolution)} = S * Fn = \text{feed per minute}$
 $F \text{ (IPM, inch/per minute)} = S * Fz * n, \text{flutes} = \text{feed per minute}$
 $sfm = S * D * \pi / 1000$

TURNING CARBIDE INSERT