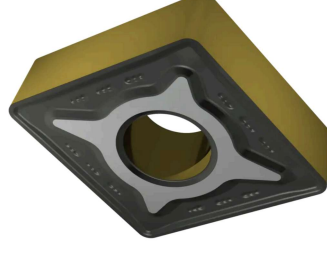




CNMG.RM 432 Z25



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 ≤ 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	935 - 1427	558 - 853	886 - 1345		164 - 377	
Fn inch/Z	0.0079 - 0.0197	0.0087 - 0.0177	0.0079 - 0.0197		0.0087 - 0.0138	
ap inch	0.039 - 0.276	0.039 - 0.276	0.039 - 0.276		0.039 - 0.22	

LEGENDA

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

FORMULA

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

TURNIN CARBIDE INSERT