



VNMG.FM 331 Z25



Double-sided Negative turning insert, chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It's also conditionally suitable for Stainless steels and Super-alloys.s. 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	771 - 968	459 - 574	722 - 919		131 - 246	
Fn inch/Z	0.0059 - 0.0079	0.0065 - 0.0071	0.0059 - 0.0079		0.0065 - 0.0079	
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

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

TURNING CARBIDE INSERT