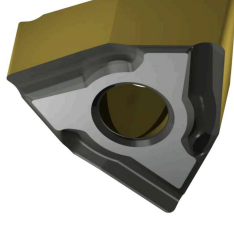




WNMG.78 431L Z25



Double-sided Negative turning insert, W - trigon, It features highly positive rake angle and highly positive, narrow T-land. M - Stainless steel, P - Steel and cast steel and Continuous cut.

GRADE 25

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			
sfm ft/min	837 - 1378	492 - 820	787 - 1296			
Fn inch/Z	0.0059 - 0.0102	0.0062 - 0.0092	0.0059 - 0.0102			
ap inch	0.016 - 0.118	0.016 - 0.118	0.016 - 0.118			

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