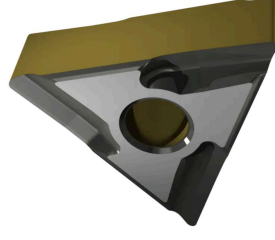




TNMG.78 331R Z25



Double-sided Negative turning insert. Combination of chipbreaker NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive. Stainless steel, P - Steel and cast steel 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	771 - 1165	459 - 689	722 - 1099		131 - 312	
Fn inch/Z	0.0059 - 0.0079	0.0062 - 0.0071	0.0059 - 0.0079		0.0062 - 0.0071	
ap inch	0.016 - 0.118	0.016 - 0.118	0.016 - 0.118		0.016 - 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) = $V_c \cdot 1000 / \pi / D = \text{rev per minute}$
F (IPR, inch per revolution) = $S \cdot F_n = \text{feed per minute}$
F (IPM, inch/per minute) = $S \cdot F_z \cdot n \cdot \text{flutes} = \text{feed per minute}$
sfm = $S \cdot D \cdot \pi / 1000$

TURNING CARBIDE INSERT