



# CPMT 32.50 Z14

## APPLICATION

- Generic grade for steel
- Suitable for fine to heavy machining of steels, stainless-steels and cast-irons



## GRADE Z14

This is a TIN PVD coated carbide insert for fine to heavy machining of steels, stainless-steels and cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M30	K30			
Sfm ft/min	427 - 558	246 - 328	394 - 525			
Fn Inch/Z	0.0031 - 0.0051	0.0035 - 0.0046	0.0031 - 0.0051			
ap Inch	0.008 - 0.118	0.008 - 0.118	0.008 - 0.118			

### LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

### FORMULA

$S \text{ (RPM)} = Sfm * 12 / \pi / D = \text{rev per minute}$
$F \text{ (IPR, inch per revolution)} = S * Fn = \text{feed per minute}$
$F \text{ (IPM, inch per minute)} = S * Fz * n.\text{flutes} = \text{feed per minute}$
$Sfm = S * D * \pi / 12$