

# TPMR.47 322 Z9



## APPLICATION

- Suitable for fine to medium machining of steels
- Continuous and interrupted cut



## GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P15 - P35, for fine to medium machining of steels

|             | STEEL       | STAINLESS   | CAST IRON   | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------|-------------|-------------|-------------|-------------|----------|--------------|
| GROUP       | P15 - P35   | M15 - M35   | K15 - K35   |             |          |              |
| Sfm ft/min  | 394 - 673   | 230 - 394   | 361 - 623   |             |          |              |
| Fn Inch/rev | .006 - .016 | .007 - .014 | .006 - .016 |             |          |              |
| ap Inch     | .031 - .157 | .031 - .157 | .031 - .157 |             |          |              |

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**