



CNMG.FM 431 Z12

APPLICATION

- Suitable for fine to medium machining of steels
- Continuous cutting conditions



GRADE Z12

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P05-P25, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K10			
Sfm ft/min	722 - 1050		673 - 984			
Fn Inch/rev	.006 - .010		.006-.010			
ap Inch	.020 - .118		.020 - .118			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT