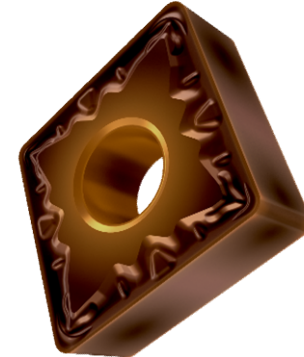




CNMG.FM 432 Z5P

APPLICATION

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



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for fine to medium machining of steels

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|--------------------|-------------|-------------|-------------|-------------|-------------|--------------|
| GROUP | P35 | M30 | K25 | | S30 | |
| Sfm ft/min | 509 - 919 | 279 - 492 | 427 - 755 | | 82 - 230 | |
| Fn Inch/rev | .006 - .018 | .006 - .016 | .006-.018 | | .006 - .014 | |
| ap Inch | .031 - .118 | .031 - .118 | .031 - .118 | | .031 - .094 | |

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT