

CNMG.M 431 Z9



APPLICATION

- Suitable for fine to heavy machining of steels
- Interrupted and continuous cut



GRADE Z9

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

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|--------------------|-------------|-----------|-------------|-------------|----------|--------------|
| GROUP | P25 | | K20 | | | |
| Sfm ft/min | 558 - 755 | | 525 - 705 | | | |
| Fn Inch/rev | .007 - .010 | | .007 - .010 | | | |
| ap Inch | .031 - .236 | | .031 - .236 | | | |

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