



CNMG.M 432 Z7

APPLICATION

- Suitable for fine to heavy machining of steels
- Interrupted cutting conditions



GRADE Z7

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P20-P45, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35					
Sfm ft/min	427 - 771					
Fn Inch/rev	.007 - .020					
ap Inch	.031 - .236					

LEGEND

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

FORMULA

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