

CNMG.M 542 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	476 - 886		443 - 837			
Fn Inch/rev	.007 - .020		.007 - .020			
ap Inch	.031 - .276		.031 - .276			

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