



CNMG.M 643 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	377 - 787					
Fn Inch/rev	.007 - .030					
ap Inch	.047 - .315					

LEGEND

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

FORMULA

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