



# CNMG.M 644 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
<b>GROUP</b>	P35					
<b>Sfm ft/min</b>	377 - 820					
<b>Fn Inch/rev</b>	.007 - .032					
<b>ap Inch</b>	.063 - .315					

### LEGEND

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

### FORMULA

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