



# CNMG.M 644 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
<b>GROUP</b>	P25		K20			
<b>Sfm ft/min</b>	443 - 951		410 - 902			
<b>Fn Inch/rev</b>	.007 - .032		.007 - .032			
<b>ap Inch</b>	.063 - .315		.063 - .315			

### LEGEND

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

### FORMULA

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