



CNMG.NF 431 Z9



APPLICATION

- Suitable fine to medium machining of steels and stainless-steels
- Continuous and interrupted cutting conditions

GRADE Z9

This is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25	M25	K25		S25	
Sfm ft/min	541 - 951	312 - 558	509 - 902		82 - 246	
Fn Inch/rev	.006 - .010	.006 - .009	.006 - .010		.006 - .009	
ap Inch	.016 - .118	.016 - .118	.016 - .118		.016 - .094	

LEGEND

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

FORMULA

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