

# RCMT.UR 0803MOE Z9



## APPLICATION

- Suitable for fine to heavy machining of steels and stainless-steels
- Continuous and interrupted cut



## GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30, for fine to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35	M10 - M30	K15 -K35			
Sfm ft/min	591 - 1115	344 - 656	558 - 1050			
Fn Inch/rev	.006 - .020	.007 - .018	.006 - .020			
ap Inch	.013 - .118	.013 - .118	.013 - .118			

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**