

RCMT.UR 1204MOE 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	410 - 1001	246 - 591	377 - 935			
Fn Inch/rev	.007 - .039	.007 - .035	.007 - .039			
ap Inch	.019 - .189	.019 - .189	.019 - .189			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT