

# SNMG.RM 544 Z7



## APPLICATION

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



## GRADE Z7

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P20 - P45 and M15 - M40, for medium to heavy machining of steels and stainless-steels

|                    | STEEL       | STAINLESS   | CAST IRON | NON FERROUS | S.ALLOYS    | HEAT TREATED |
|--------------------|-------------|-------------|-----------|-------------|-------------|--------------|
| <b>GROUP</b>       | P20 - P45   | M15 -M40    |           |             | S20 -S45    |              |
| <b>Sfm ft/min</b>  | 443 - 787   | 262 - 459   |           |             | 66 - 197    |              |
| <b>Fn Inch/rev</b> | .012 - .032 | .013 - .028 |           |             | .013 - .022 |              |
| <b>ap Inch</b>     | .079 - .315 | .079 - .315 |           |             | .079 - .252 |              |

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

**TURNING CARBIDE INSERT**