

# SNMG.RM 644 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 - 755	262 - 443			66 - 197	
<b>Fn Inch/rev</b>	.012 - .032	.013 - .028			.013 - .022	
<b>ap Inch</b>	.079 - .394	.079 - .394			.079 - .315	

### 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**