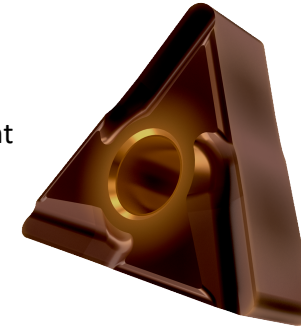


TNMG.78 331R Z5P



APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels with a right handed turning tool
- Continuous and interrupted cut



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for medium to heavy machining of steels and stainless-steels with a right handed turning tool

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20 - M35		N25 - N40	S25 - S40	
Sfm ft/min	541 - 656	295 - 361		738 - 2116	82 - 164	
Fn Inch/rev	.007 - .008	.007 - .007		.007 - .009	.007 - .007	
ap Inch	.031 - .197	.031 - .197		.031 - .197	.031 - .157	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT