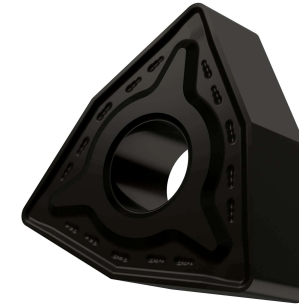


# WNMG.RM 432 Z12



## APPLICATION

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



## GRADE Z12

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05-P25, for medium to heavy machining of steels

|             | STEEL       | STAINLESS | CAST IRON   | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------|-------------|-----------|-------------|-------------|----------|--------------|
| GROUP       | P05 - P25   |           | K05 - K25   |             |          |              |
| Sfm ft/min  | 640 - 1083  |           | 607 - 1017  |             |          |              |
| Fn Inch/rev | .008 - .021 |           | .008 - .021 |             |          |              |
| ap Inch     | .039 - .197 |           | .039 - .197 |             |          |              |

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**