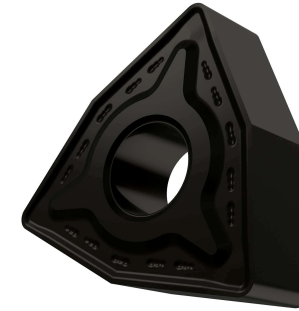


WNMG.RM 432 Z9



APPLICATION

- Suitable for medium 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 medium 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		S15 - S35	
Sfm ft/min	558 - 984	328 - 591	525 - 935		98 - 262	
Fn Inch/rev	.008 - .021	.009 - .019	.008 - .021		.009 - .014	
ap Inch	.039 - .197	.039 - .197	.039 - .197		.039 - .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)	$= Sfm * 12 / \pi / D = \text{rev per minute}$
F (IPR, inch per revolution)	$= S * Fn = \text{feed per minute}$
F (IPM, inch per minute)	$= S * Fz * n.\text{flutes} = \text{feed per minute}$
Sfm	$= S * D * \pi / 12$

TURNING CARBIDE INSERT