

SNMG.RM 432 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
GROUP	P20 - P45	M15 -M40			S20 -S45	
Sfm ft/min	541 - 853	312 - 509			82 - 230	
Fn Inch/rev	.008 - .017	.009 - .016			.009 - .012	
ap Inch	.039 - .276	.039 - .276			.039 - .22	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT