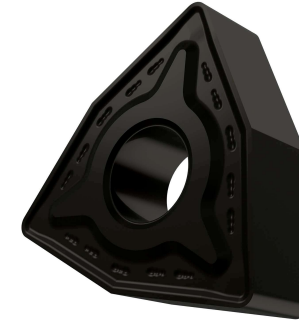


WNMG.RM 432 Z7



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	P05 - P25		K05 - K25			H05 - H25
Sfm ft/min	492 - 837		295 - 492			82 - 213
Fn Inch/rev	.008 - .021		.009 - .019			.009 - .014
ap Inch	.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 / π / 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 * π / 12

TURNING CARBIDE INSERT