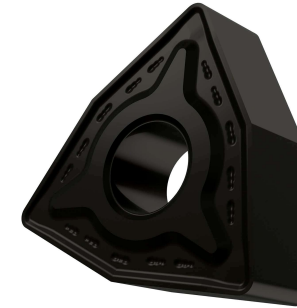


WNMG.RM 434 Z9



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	541 - 886	312 - 525	509 - 837		82 - 230	
Fn Inch/rev	.012 - .030	.013 - .027	.012 - .024		.013 - .021	
ap Inch	.079 - .197	.079 - .197	.079 - .197		.079 - .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