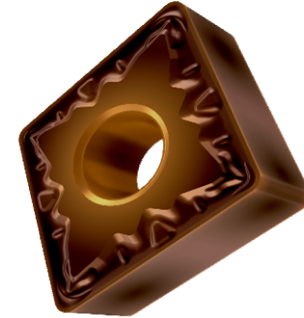




# CNMG.FM 322 Z5P

## APPLICATION

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



## GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P35	M30	K25		S30	
<b>Sfm ft/min</b>	509 - 919	279 - 492	427 - 755		82 - 230	
<b>Fn Inch/rev</b>	.004 - .010	.004 - .010	.004-.010		.004 - .007	
<b>ap Inch</b>	.020 - .118	.020 - .118	.020 - .118		.020 - .094	

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**