



CNMG.NF 431 Z7

APPLICATION

- Suitable fine to medium machining of steels and stainless-steels
- Interrupted cutting conditions



GRADE Z7

This is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P25-P40 and M30-M40

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35	K35		S35	
Sfm ft/min	558 - 1083	328 - 640	525 - 1017		98 - 279	
Fn Inch/rev	.005 - .011	.006- .010	.006 - .012		.006 - .010	
ap Inch	.016 - .118	.016 - .118	.016 - .118		.016 - .095	

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	$S * D * \pi / 12$