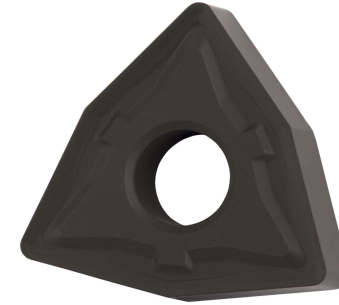


# WNMG.R 432 Z7



## APPLICATION

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



## GRADE Z7

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P20-P45, for medium to heavy machining of steels

|             | STEEL       | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------|-------------|-----------|-----------|-------------|----------|--------------|
| GROUP       | P20 - P45   |           |           |             |          |              |
| Sfm ft/min  | 427 - 640   |           |           |             |          |              |
| Fn Inch/rev | .010 - .021 |           |           |             |          |              |
| ap Inch     | .079 - .22  |           |           |             |          |              |

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**