

SNMG.RM 433 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	P20 - P45	M15 -M40			S20 -S45	
Sfm ft/min	492 - 820	295 - 492			82 - 213	
Fn Inch/rev	.010 - .026	.011 - .023			.011 - .018	
ap Inch	.059 - .276	.059 - .276			.059 - .22	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT