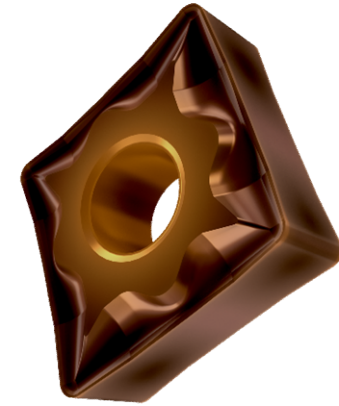


CNMG.NF 431 Z5P



APPLICATION

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



GRADE Z5P

This is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M35	K30	N30	S35	
Sfm ft/min	427 - 804	230 - 443	344 - 656	591 - 2575	66 - 197	
Fn Inch/rev	.005 - .010	.005 - .009	.005 - .010	.005 - .012	.005 - .008	
ap Inch	.016 - .118	.016 - .118	.016 - .118	.016 - .118	.016 - .094	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT