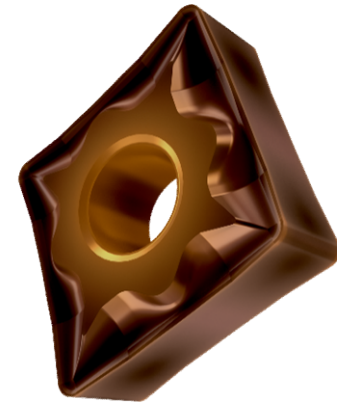




# CNMG.NF 433 Z5P

## 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. Medium wide positive T-land improves the cutting edge strength allowing light to medium feeds and enabling versatile machining with lower cutting forces

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P35	M35	K30	N30	S35	
<b>Sfm ft/min</b>	476 - 919	262-492	394 -755	656 - 2920	82 - 230	
<b>Fn Inch/rev</b>	.006 - .014	.006- .012	.006 - .014	.006 - .017	.006 - .010	
<b>ap Inch</b>	.047 - .157	.047 - .157	.047 - .157	.047 - .157	.047 - .126	

### LEGEND

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

### FORMULA

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