



# CNMG.FM 321 Z12

## APPLICATION

- Suitable for fine to medium machining of steels and stainless-steels
- Continuous cut



## GRADE Z12

This is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05-P25, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P15		K15			
<b>Sfm ft/min</b>	722 - 1050		673 - 984			
<b>Fn Inch/rev</b>	.006 - .010		.006-.010			
<b>ap Inch</b>	.020 - .118		.020 - .118			

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**