



CNMG.FM 432 Zi9

APPLICATION

- Suitable for fine to medium machining of stainless steels
- Continuous cutting conditions



GRADE Zi9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges M25, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25	M25			S20	
Sfm ft/min	558 - 869	427 - 673			131 - 328	
Fn Inch/rev	.006 - .017	.006 - .016			.006 - .014	
ap Inch	.031 - .118	.031 - .118			.031 - .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