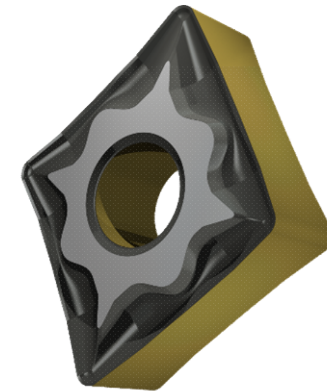




CNMG.NF 432 Z15

APPLICATION

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



GRADE Z15

a MT-CVD coated functionally graded WC-Co carbide within ISO range P05 - P30, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K15			
Sfm ft/min	722 - 1345		673 - 1263			
Fn Inch/rev	.006 - .014		.006 - .014			
ap Inch	.031 - .138		.031 - .138			

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 / π / 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 * π / 12