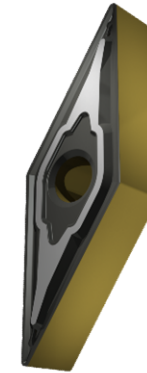


# VNMG.M 331 Z15



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

## APPLICATION



## GRADE Z15

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P05 - P30		K05 - K30			H15
<b>Sfm ft/min</b>	574 - 722		541 - 673			115 - 131
<b>Fn Inch/rev</b>	.006 - .008		.006 - .008			.004 - .005
<b>ap Inch</b>	.031 - .118		.031 - .118			.008 - .020

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**