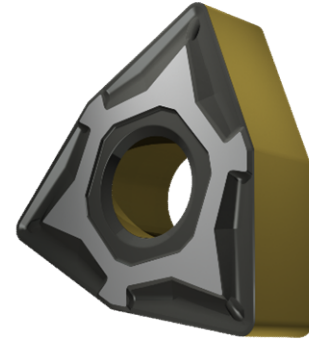


WNMG.M 432 Z15



- 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
GROUP	P05 - P30		K05 - K30			H15
Sfm ft/min	673 - 1122		623 - 1066			131 - 213
Fn Inch/rev	.007 - .020		.007 - .020			.004 - .010
ap Inch	.031 - .220		.031 - .220			.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT