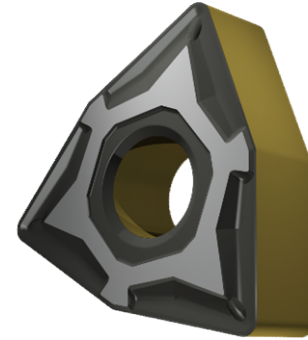


WNMG.M 331 Z15



- 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
GROUP	P05 - P30		K05 - K30			H15
Sfm ft/min	771 - 1050		722 - 984			148 - 197
Fn Inch/rev	.006 - .010		.006 - .010			.004 - .007
ap Inch	.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

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

CV