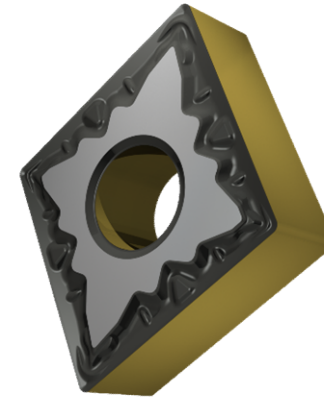




CNMG.FM 431 Z15

APPLICATION

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



GRADE Z15

This grade is 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		K10			
Sfm ft/min	837 - 1165		787 - 1099			
Fn Inch/rev	.006 - .010		.006-.010			
ap Inch	.020 - .118		.020 - .118			

LEGEND

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

FORMULA

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