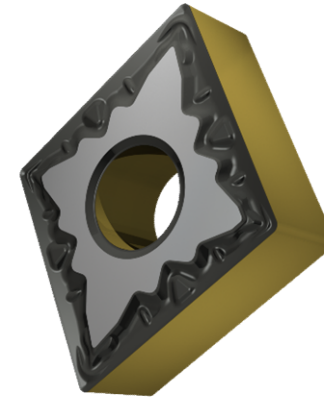




# CNMG.FM 432 Z15

## 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
<b>GROUP</b>	P15		K10			
<b>Sfm ft/min</b>	837 - 1362		787 - 1280			
<b>Fn Inch/rev</b>	.006 - .017		.006-.017			
<b>ap Inch</b>	.031 - .118		.031 - .118			

### LEGEND

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

### FORMULA

**S (RPM)** =  $Sfm * 12 / \pi / D$  = 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** =  $S * D * \pi / 12$

**TURNING CARBIDE INSERT**