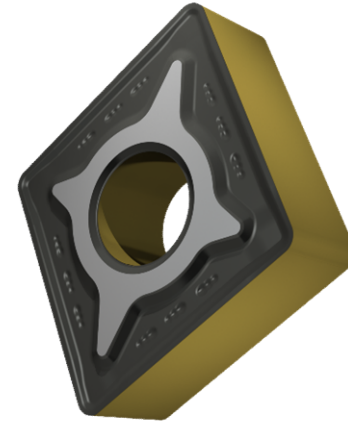


CNMG.RM 432 Z15



APPLICATION

- Suitable for medium to heavy 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 medium to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10-P25	M10-M25				
Sfm ft/min	755 -1198	705 - 1032				
Fn Inch/rev	.008 - .020	.0087 - .0197				
ap Inch	.039 - .276	.039 - .276				

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT