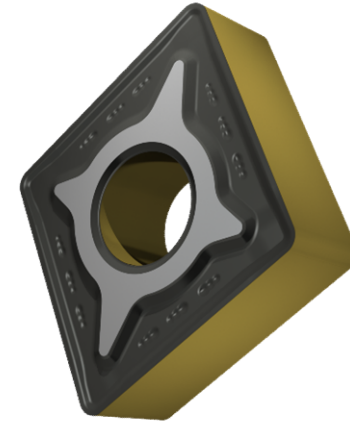


CNMG.RM 433 Z15



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

APPLICATION



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		P10-P25			
Sfm ft/min	705 -1165		656 - 1099			
Fn Inch/rev	.010 .027		.010 .027			
ap Inch	.059 - .276		.059 - .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