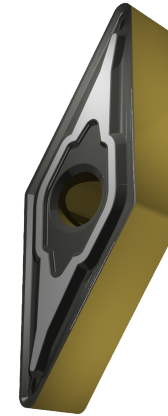




VNMG.M 332 Z15

APPLICATION

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



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 | | K20 | | | H15 |
| Sfm ft/min | 541 - 869 | | 509 - 820 | | | 98 - 164 |
| Fn Inch/Z | 0.0059 - 0.0157 | | 0.0059 - 0.0157 | | | 0.0043 - 0.0079 |
| ap Inch | 0.031 - 0.118 | | 0.031 - 0.118 | | | 0.016 - 0.039 |

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT