

DNMG.FM 331 Z5P



APPLICATION

- Suitable for fine to medium machining of steels
- Continuous and interrupted cut



GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO range P25-P40, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25-P40	M25 - M40	K25 - K40		S25 - S40	
Sfm ft/min	459 - 722	246 - 394	377 - 591		66 - 180	
Fn Inch/rev	.004 - .008	.004 - .007	.004 - .008		.004 - .006	
ap Inch	.016 - .118	.016 - .118	.016 - .118		.016 - .094	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT