

# DNMG.FM 432 Z12



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



## APPLICATION

## GRADE Z12

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05-P25, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P05-P25		K05 - K25			
<b>Sfm ft/min</b>	574 - 984		541 - 935			
<b>Fn Inch/rev</b>	.006 - .016		.006 - .016			
<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

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

**TURNING CARBIDE INSERT**