



# DNMG.FM 432 Z5P

## APPLICATION

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



## GRADE Z5P

This grade is a PVD coated fine grained WC-Co carbide within ISO ranges P25-P40 and M20-M35, for fine to medium machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P35	M35	K35		S 35	
<b>Sfm ft/min</b>	427 - 722	230 - 394	344 - 591		66 - 180	
<b>Fn Inch/Z</b>	0.006 - 0.015	0.0065 - 0.014	0.006 - 0.015		0.006 - 0.013	
<b>ap Inch</b>	0.031 - 0.118	0.031 - 0.118	0.031 - 0.118		0.031 - 0.094	

### 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**