



DNMG.M 433 Z12

APPLICATION

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



GRADE Z12

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P05 - P25		K05 - K25			H05 - K25
Sfm ft/min	443 - 853		410 - 804			82 - 164
Fn Inch/rev	.007 - .024		.007 - .024			.004 - .012
ap Inch	.047 - .177		.047 - .177			.024 - .055

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT