



DNMG.M 433 Z9

APPLICATION

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



GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P15-P35, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35		K15 - K35			
Sfm ft/min	394 - 771		361 - 722			
Fn Inch/rev	.007 - .024		.007 - .024			
ap Inch	.047 - .177		.047 - .177			

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