

DNMG.FM 332 Z9



APPLICATION

- Suitable for fine to medium 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 medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35	M15-M35	K15-K35		S15-S35	
Sfm ft/min	541 - 886	312 - 525	509 - 837		82 - 230	
Fn Inch/rev	.006 - .014	.007 - .012	.006 - .014		.006 - .011	
ap Inch	.031 - .118	.031 - .118	.031 - .118		.031 - .094	

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT