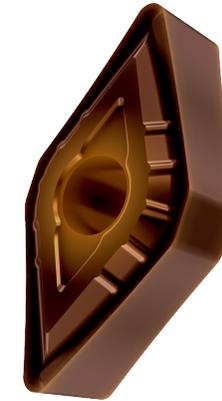




DNMG.SF 431 Z5P

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
GROUP	P25 - P40	M20 - M35	K25 - K40	N25 - N40	S25 - S40	H25 - H40
Sfm ft/min	312 - 689	164 - 377	262 - 574	443 - 2231	49 - 180	49 - 115
Fn Inch/rev	.004 - .008	.004 - .007	.004 - .008	.004 - .009	.004 - .006	.004 - .006
ap Inch	.016 - .098	.016 - .098	.016 - .098	.016 - .098	.016 - .079	.008 - .02

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT