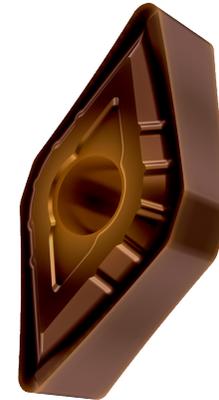




DNMG.SF 432 Z5P

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
GROUP	P25 - P40	M20 - M35	K25 - K40	N25 - N40	S25 - S40	H25 - H40
Sfm ft/min	328 - 755	180 - 410	279 - 607	459 - 2411	49 - 180	49 - 115
Fn Inch/rev	.005 - .011	.005 - .009	.005 - .011	.005 - .013	.005 - .009	.004 - .007
ap Inch	.031 - .118	.031 - .118	.031 - .118	.031 - .118	.031 - .094	.016 - .039

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / D = rev per minute
F (IPR, inch per revolution) = S * Fn = feed per minute
F (IPM, inch per minute) = S * Fz * n.flutes = feed per minute
Sfm = S * D * π / 12

TURNING CARBIDE INSERT