



DNMG.M 431 Z15

APPLICATION

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



GRADE Z15

Z15 is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05 - P30, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P35		K15 - K35			H10
Sfm ft/min	656 - 804		623 - 755			131 - 148
Fn Inch/rev	.007 - .008		.007 - .008			.004 - .006
ap Inch	.031 - .118		.031 - .118			.008 - .020

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