



# DNMG.FM 431 Z15

## APPLICATION

- Suitable for fine to medium machining of steels
- Continuous cutting conditions



## GRADE Z15

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

|                    | STEEL       | STAINLESS | CAST IRON   | NON FERROUS | S.ALLOYS | HEAT TREATED |
|--------------------|-------------|-----------|-------------|-------------|----------|--------------|
| <b>GROUP</b>       | P15         |           | K10         |             |          |              |
| <b>Sfm ft/min</b>  | 738 - 935   |           | 689 - 886   |             |          |              |
| <b>Fn Inch/rev</b> | .006 - .008 |           | .006-.008   |             |          |              |
| <b>ap Inch</b>     | .020 - .118 |           | .020 - .118 |             |          |              |

### LEGEND

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

### FORMULA

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