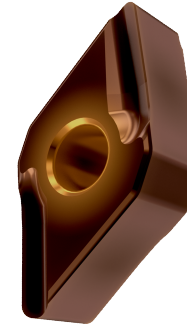


DNMG.78 331L Z5P



APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels with a left handed turning tool
- 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 medium to heavy machining of steels and stainless-steels with a left handed turning tool

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25 - P40	M20 - M35		N25 - N40	S25 - S40	
Sfm ft/min	541 - 640	295 - 344		738 - 2067	82 - 164	
Fn Inch/rev	.007 - .008	.007 - .007		.007 - .009	.007 - .007	
ap Inch	.031 - .13	.031 - .13		.031 - .13	.031 - .104	

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)	$F = S * Fz * n.\text{flutes} = \text{feed per minute}$
Sfm	$S = S * D * \pi / 12$

TURNING CARBIDE INSERT