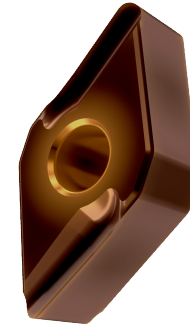


DNMG.78 331R Z5P



APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels with a right 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 right 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)	= 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