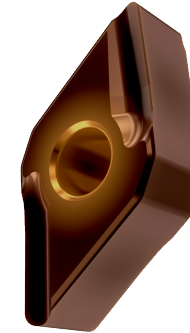


DNMG.78 332L Z5P



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



APPLICATION

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 | 476 - 722 | 262 - 394 | | 656 - 2297 | 82 - 180 | |
| Fn Inch/rev | .008 - .016 | .009 - .014 | | .008 - .019 | .009 - .011 | |
| 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