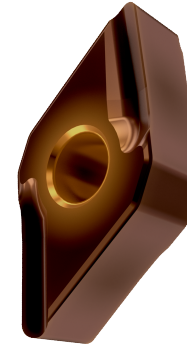


# DNMG.78 432L Z5P



## 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	459 - 689	246 - 377		640 - 2231	66 - 180	
Fn Inch/rev	.008 - .016	.009 - .014		.008 - .019	.009 - .011	
ap Inch	.031 - .177	.031 - .177		.031 - .177	.031 - .142	

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**