

DNMG.78 432R Z9



APPLICATION

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



GRADE Z9

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P15-P35 and M10-M30, 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	P15 - P35	M10 - M30			S15 - S35	
Sfm ft/min	574 - 853	344 - 509			98 - 230	
Fn Inch/rev	.008 - .016	.009 - .014			.009 - .011	
ap Inch	.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 (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