

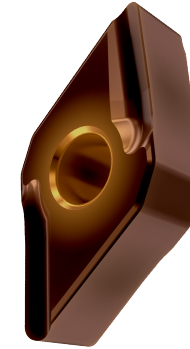
# DNMG.78 431L Z5P



- 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
<b>GROUP</b>	P25 - P40	M20 - M35		N25 - N40	S25 - S40	
<b>Sfm ft/min</b>	509 - 640	279 - 344		705 - 2067	82 - 164	
<b>Fn Inch/rev</b>	.007 - .008	.007 - .007		.007 - .009	.007 - .007	
<b>ap Inch</b>	.016 - .177	.016 - .177		.016 - .177	.016 - .142	

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**