

DNMG.78 431L Z9



APPLICATION

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

| | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|--------------------|-------------|-------------|-----------|-------------|-------------|--------------|
| GROUP | P15 - P35 | M10 - M30 | | | S15 - S35 | |
| Sfm ft/min | 640 - 787 | 377 - 459 | | | 115 - 197 | |
| Fn Inch/rev | .007 - .008 | .007 - .007 | | | .007 - .007 | |
| ap Inch | .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

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

TURNING CARBIDE INSERT