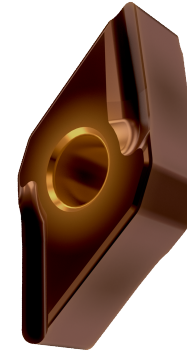


# DNMG.78 431R Z5P



## APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels with a right 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 right 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	509 - 640	279 - 344		705 - 2067	82 - 164	
Fn Inch/rev	.007 - .008	.007 - .007		.007 - .009	.007 - .007	
ap Inch	.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> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn = feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes = feed per minute
<b>Sfm</b> = S * D * π / 12

**TURNING CARBIDE INSERT**