



DNMG.RM 432 Z7

APPLICATION

- Suitable for medium to heavy machining of steels and stainless-steels
- Continuous and interrupted cut



GRADE Z7

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO ranges P20-P45 and M15-M40, for medium to heavy machining of steels and stainless-steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20 - P45	M15 - M40			S20 - S45	
Sfm ft/min	443 - 623	262 - 361			66 - 164	
Fn Inch/rev	.010 - .016	.011 - .014			.011 - .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)	$S = \frac{Sfm * 12}{\pi * D}$ = 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