

DNMG.RM 432 Z12



- Suitable for fine to heavy machining of steels
- Continuous cut

APPLICATION



GRADE Z12

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05-P15, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15 - P15		K15 - K15			
Sfm ft/min	574 - 787		541 - 738			
Fn Inch/rev	.010 - .016		.010 - .016			
ap Inch	.031 - .177		.031 - .177			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT