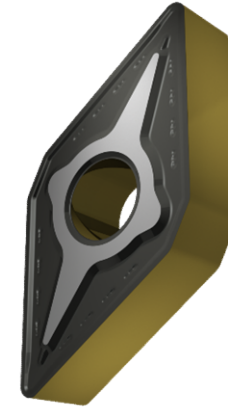




DNMG.RM 432 Z15

APPLICATION

- Suitable for fine to medium machining of steels
- Continuous cutting conditions



GRADE Z15

This grade is a MT-CVD coated functionally graded WC-Co carbide within ISO range P05 - P30, for fine to medium machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K10			
Sfm ft/min	689 - 919		640 - 869			
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

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

TURNING CARBIDE INSERT