



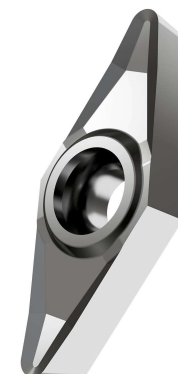
# VCGT 221 ZKX

## APPLICATION

- Suitable for fine to heavy machining of non-ferrous metals
- Continuous and interrupted cut

## GRADE ZKX

This grade is an uncoated fine grained WC-Co carbide within ISO range N10-N25, for fine to heavy machining of non-ferrous metals



|             | STEEL | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------|-------|-----------|-----------|-------------|----------|--------------|
| GROUP       |       |           |           | N10 - N25   |          |              |
| Sfm ft/min  |       |           |           | 361 - 1312  |          |              |
| Fn Inch/rev |       |           |           | .004 - .009 |          |              |
| ap Inch     |       |           |           | .016 - .108 |          |              |

## LEGEND

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

## FORMULA

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

**TURNING CARBIDE INSERT**