



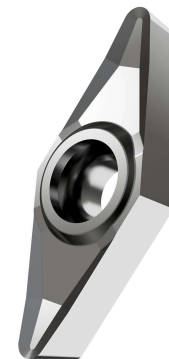
VCGT 220 ZKX

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				459 - 1493		
Fn Inch/rev				.002 - .005		
ap Inch				.012 - .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