



CNGN 431 T2 ZCC

APPLICATION

- Suitable for medium heat treated material (up to HRC 60) and cast irons
- Continuous low speed turning of hardened steel



GRADE ZCC

Grade ZCC ceramic in its outstanding wear resistance and thermal shock resistance with high speed cutting. Pure raw materials give stability and fine microstructure to the products. Through HIP process, shaped bodies are completely condensed so that finished goods are strong and resistant against fracture and wear. Excellent wear resistance. $Al_2O_3 + TiC(N)$.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K 20			> 56 Rck
Sfm ft/min			800-5000			200-700
Fn Inch/rev			.010-.025			.002-.010
ap Inch			.050-.200			.020-.040

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 CERAMIC INSERT