

# DNMA 432 Z11H



## APPLICATION

- Suitable for fine to medium machining of cast-irons
- Continuous and interrupted cut



## GRADE Z11H

This grade is a MT-CVD coated WC-Co carbide within ISO range K01-K15, for fine to medium machining of cast-irons

|             | STEEL | STAINLESS | CAST IRON   | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------|-------|-----------|-------------|-------------|----------|--------------|
| GROUP       |       |           | K01 - K15   |             |          | H01 - H15    |
| Sfm ft/min  |       |           | 443 - 837   |             |          | 82 - 164     |
| Fn Inch/rev |       |           | .004 - .006 |             |          | .004 - .008  |
| ap Inch     |       |           | .031 - .154 |             |          | .016 - .039  |

### 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**