



DNMG.M 432 Z11

APPLICATION

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



GRADE Z11

This grade is a MT-CVD coated WC-Co carbide within ISO range K10-K25, for fine to heavy machining of cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10 - P25		K10 - K25			H10 - H25
Sfm ft/min	558 - 869		525 - 820			98 - 164
Fn Inch/rev	.006 - .016		.006 - .016			.004 - .008
ap Inch	.031 - .177		.031 - .177			.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT