

TNMA 433 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			476 - 902			98 - 180
Fn Inch/rev			.004 - .016			.004 - .008
ap Inch			.047 - .252			.024 - .055

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