



# CNMG.AL 431 ZSC

## APPLICATION

- Suitable for steel and stainless steel and super alloy



## GRADE ZSC

TiAlN + SC(silicon) coating over an ultra-fine carbide substrate of high strength and toughness. Suitable for turning all kinds of materials, as well as rough turning of high-temperature alloys.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>		M25		N25	S30	
<b>Sfm ft/min</b>		585 - 900		500 - 1450	100 - 200	
<b>Fn Inch/rev</b>		.004 - .012		.004 - .025	.004 - .010	
<b>ap Inch</b>		.020 - .090		.040 - .250	.020 - .044	

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**