



# VCGT 220515 ZKX



## APPLICATION

- Suitable for machining of non-ferrous metal with end mills ALLY
- Single-sided milling insert VCGT 2205 with chip-breakers, 35° rhomboid for a maximum depth of cut of .787"

## GRADE ZKX

This is an uncoated fine grained WC-Co carbide within ISO-grade range N10-N25 for machining of non-ferrous metal with end mills ALLY

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>				K10		
<b>Sfm ft/min</b>				197 - 1033		
<b>Fn Inch/Z</b>				0.002 - 0.0354		
<b>ap Inch</b>				0.02 - 0.787		

### LEGEND

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

### FORMULA

<b>S (RPM)</b> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn= feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes= feed per minute
<b>Sfm</b> = S * D * π / 12