



TNMG 331 ZC2

APPLICATION

- Suggested for finishing operations with high feed rate
- Suitable for fine to heavy machining of steels



GRADE ZC2

This is an uncoated cermet insert within ISO range P10-P25, for fine to heavy machining of steels

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20					
Sfm ft/min	705 - 1001					
Fn Inch/Z	0.0039 - 0.0079					
ap Inch	0.02 - 0.118					

LEGEND

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

FORMULA

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

