



# GFN 3 Z11

## APPLICATION

- Suitable for machining steel and cast iron
- 0° front angle for grooving and parting off



## GRADE Z11

This is a ALN PVD coated carbide for machining of steel and cast irons.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P20	M20	K15			
Sfm ft/min	230 - 427	131 - 246	213 - 394			
Fn Inch/Z	0.0031 - 0.0079	0.0035 - 0.0071	0.0031 - 0.0079			
ap Inch						

### 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