



VNGA 331 T7 ZCC

APPLICATION

- Suitable for machining of heat treated steel and cast iron
- Excellent wear resistance Al₂O₃+TiCN



GRADE ZCC

This is a ceramic insert and it is basic choice for machining hardened steel and alloy steel. It has an outstanding wear resistance and thermal shock resistance with high speed cutting.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K10			> 56 HRC
Sfm ft/min			1198 - 2149			200 - 700
Fn Inch/Z			0.002 - 0.0087			.002 - .010
ap Inch			0.031 - 0.114			.020 - .040

LEGEND

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

FORMULA

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

CERAMIC INSERT