



TNMA 333 Z11H

APPLICATION

- Suitable for fine to medium machining of cast-irons
- Continuous and interrupted cut



GRADE Z11H

This grade is a MT-CVD coated WC-Co carbide within ISO range K01-K15, for fine to medium machining of cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K01 - K15			H01 - H15
Sfm ft/min			476 - 919			98 - 180
Fn Inch/rev			.004 - .016			.004 - .008
ap Inch			.047 - .189			.024 - .055

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT