



# CNGA 433 T7 ZCC

## APPLICATION

- Suitable for medium heat treated material (up to HRC 60) and cast irons
- Continuous low speed turning of hardened steel



## GRADE ZCC

Grade ZCC ceramic in its outstanding wear resistance and thermal shock resistance with high speed cutting. Pure raw materials give stability and fine microstructure to the products. Through HIP process, shaped bodies are completely condensed so that finished goods are strong and resistant against fracture and wear. Excellent wear resistance. Al<sub>2</sub>O<sub>3</sub> +TiC(N).

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>			K 20			> 56 Rck
<b>Sfm ft/min</b>			1427 - 2969			200-700
<b>Fn Inch/rev</b>			.002-.013			.002-.010
<b>ap Inch</b>			.031-.236			.020-.040

### LEGEND

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

### FORMULA

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