



TPGN 321 T2 ZCC

APPLICATION

- Suitable for machining of heat treated steel and cast iron
- Excellent wear resistance Al_2O_3+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			
Sfm ft/min			1280 - 1952			
Fn Inch/Z			0.002 - 0.0051			
ap Inch			0.016 - 0.15			

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