

TNMA 432 Z11



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 K10-K25, for fine to medium machining of cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K10 - K25			H10 - H25
Sfm ft/min			394 - 722			82 - 148
Fn Inch/rev			.004 - .016			.004 - .008
ap Inch			.031 - .252			.016 - .039

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT