

CNMG.RM 432 Z11H



APPLICATION

- Suitable for fine to heavy machining of cast-irons
- Continuous cutting conditions



GRADE Z11H

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P01-P15		K01-K15			
Sfm ft/min	804 - 1247		755 - 1181			
Fn Inch/rev	.008 - .020		.008 - .020			
ap Inch	.039 - .276		.039 - .276			

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