

CNMG.RM 433 Z11



APPLICATION

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



GRADE Z11

This is a MT-CVD coated WC-Co carbide within ISO range K10-K25, for medium to heavy machining of cast-irons

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10-P25		K10-K25			
Sfm ft/min	673 - 1066		623 - 1001			
Fn Inch/rev	.010 - .028		.010 - .028			
ap Inch	.059 - .276		.059 - .276			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT