

CNMG.SF 432 ZKX



APPLICATION

- Suitable for fine to medium machining of cast-irons, aluminum and super-alloys
- Continuous and interrupted cut



GRADE ZKX

This uncoated grade is fine grained WC-Co carbide within ISO range K10 - K25 and S01 - S20, for fine to medium machining of cast-irons, aluminum and super-alloys

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP		M10 - M20	K10 - K25	N10 - N20	S01 - S20	
Sfm ft/min		164 - 394	279 - 640	443 - 2362	66 - 246	
Fn Inch/rev		.005 - .017	.005 - .012	.005 - .014	.005 - .009	
ap Inch		.031 - .118	.031 - .118	.031 - .118	.031 - .094	

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