

CNGG.SF 430 Z12P



APPLICATION

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



GRADE Z12P

It is an uncoated WC-Co carbide within ISO ranges K10 - K25 and S01 - S20, for fine to medium machining of cast-irons and super-alloys

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10 - P25	M10 - M25	K10 - K25	N10 - N25	S10 - S25	H15
Sfm ft/min	492 - 902	246 - 459	443 - 820	607 - 2641	82 - 246	82 - 148
Fn Inch/rev	.003 - .005	.003 - .004	.003 - .005	.003 - .006	.003 - .004	.003 - .005
ap Inch	.008 - .098	.008 - .098	.008 - .098	.008 - .098	.008 - .079	.006 - .009

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT