



GTN 3 Z11

APPLICATION

- Suitable for machining steel and cast iron
- straight front angle for grooving or parting off



GRADE Z11

This CVD coated fine grained WC-Co carbide within ISO-grade ranges P10 -P20 and K05 -K=20 for machining of steel and cast iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K10			
Sfm ft/min	295 - 492		279 - 459			
Fn Inch/Z	0.0031 - 0.0079		0.0031 - 0.0079			
ap Inch						

LEGEND

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

FORMULA

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