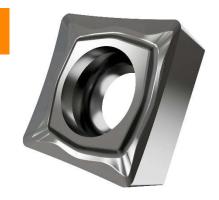


SCGT 432 ZKX

APPLICATION

- Single-sided positive turning insert, square with 7° clearance
- Suggested for machining of aluminum and non ferrous material



GRADE ZKX

This is a an uncoated fine grained WC-Co carbide within ISO range N10-N25, for fine to heavy machining of non-ferrous metals

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP				K10		
Sfm ft/min				443 - 1837		
Fn Inch/Z				0.0059 - 0.0208		
ap Inch				0.031 - 0.276		

LEGEND

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

FORMULA

S (RPM) = Sfm * 12 / π / D = rev per minute F (IPR, inch per revolution) = S * Fn= feed per minute F (IPM, inch per minute) = S * Fz * n.flutes= feed per minute Sfm = S * D * π / 12