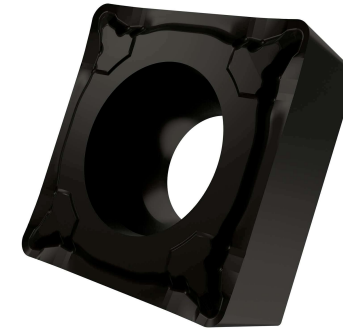




SCMT.UR 432 Z11

APPLICATION

- Suitable for fine to heavy machining of cast-irons
- Continuous and interrupted cut



GRADE Z9

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10 - P25		K10 -K25			
Sfm ft/min	623 - 1148		591 - 1083			
Fn Inch/rev	.004 - .017		.004 - .017			
ap Inch	.031 - .157		.031 - .157			

LEGEND

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

FORMULA

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

TURNING CARBIDE INSERT