



CNMA 432 Z11H

APPLICATION

- Suitable for fine to heavy machining of cast-irons



GRADE Z11H

Grade with very high resistance to chemical wear; suitable for finishing operations using high cutting speeds. With its high abrasion resistance, it is also suitable for productive K01 – K15, machining of hardened and treated materials

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K15			> 45HRC
Sfm ft/min			509 - 968			98 - 197
Fn Inch/rev			.004 - .016			.004-.008
ap Inch			.031 - .331			.016 - .039

LEGEND

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

FORMULA

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