



CNMA 433 Z11

APPLICATION

- Suitable for medium to heavy machining of cast-irons



GRADE Z11

It is a submicron grade without cubical carbides with low content of cobalt. This grade is for general purpose applications for all groups of work material except P. This grade is suitable for small up to medium chip cross section with steady cutting conditions.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K15			> 45HRC
Sfm ft/min			410 - 886			82 - 180
Fn Inch/rev			.004 - .023			.004-.012
ap Inch			.047 - .331			.024 - .058

LEGEND

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

FORMULA

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