



# CNMG.M 431 Z11

## APPLICATION

- Suitable for fine to heavy machining of cast-irons
- Continuous cutting conditions



## GRADE Z11

This 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
<b>GROUP</b>	P15		K15			H10
<b>Sfm ft/min</b>	656 - 869		623 - 820			131 - 164
<b>Fn Inch/rev</b>	.007 - .010		.007 - .010			.004 - .007
<b>ap Inch</b>	.031 - .236		.031 - .236			.008 - .020

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**