



CNMG.M 433 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
GROUP	P15		K15			H10
Sfm ft/min	574 - 1083		541 - 1017			115 - 213
Fn Inch/rev	.007 - .030		.007 - .030			.004 - .015
ap Inch	.047 - .236		.047 - .236			.024 - .059

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