

DNGA 431 T2 ZCC

APPLICATION

- General machining for hardened steel and cast iron
- Better using dry, no coolant
- Suggested to continuous cutting condition.

GRADE ZCC

Grade ZCC in its outstanding wear resistance and thermal shock resistance with high speed cutting. Pure raw materials give stability and fine microstructure to the products.

Through HIP process, shaped bodies are completely condensed so that finished goods are strong and resistant against fracture and wear. Excellent wear resistance. Al₂O₃ +TiC(N).



	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP			K10			H10
Sfm ft/min			98 - 328			98 - 492
Fn Inch/rev			.003 - .008			.002 - .013
ap Inch			.004 - .012			.004 - .012

LEGEND

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

FORMULA

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