



# VNMG.FM 332 Z11

## APPLICATION

- Suitable for fine to heavy machining of cast-irons
- Continuous and interrupted cut



## GRADE Z11

This grade 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	P10 - P25		K10 - K25			H10 - H25
Sfm ft/min	509 - 804		476 - 755			98 - 148
Fn Inch/rev	.006 - .016		.006 - .016			.004 - .008
ap Inch	.031 - .118		.031 - .118			.016 - .039

### LEGEND

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

### FORMULA

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

**TURNING CARBIDE INSERT**