



# CNMA 643 Z11H

## APPLICATION

- Suitable for fine to heavy machining of cast-irons



## GRADE Z11H

Grade with very high resistance to chemical wear; suitable for finishing operations using high cutting speeds. With its high abrasion resistance, it is also suitable for productive K01 – K15, machining of hardened and treated materials

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>			K05			> 45HRC
<b>Sfm ft/min</b>			443 - 984			82 - 197
<b>Fn Inch/rev</b>			.004 - .023			.004-.012
<b>ap Inch</b>			.047 - .500			.024 - .059

### LEGEND

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

### FORMULA

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