



SNMX.M 1205 Z5

APPLICATION

- Double-sided milling insert, square with 8 corners for a maximum depth of cut of .394".



GRADE Z5

- This is a PVD TiAlN coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30					
Sfm ft/min	594					
Fz Inch/Z	0.0197 - 0.0071					
ap Inch	0.0394					

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT