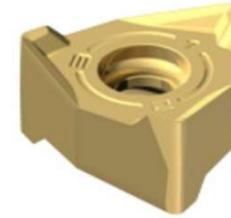




# XNEX 040304 Z3



## APPLICATION

Double-sided milling insert, trigonal shape for a maximum depth of cut of .090". It is recommended for machining of steel and stainless steel. It fits 600 milling cutters.

## GRADE Z3

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30	M30				
<b>Sfm ft/min</b>	594	374				
<b>Fz Inch/Z</b>	0.005 - 0.012	0.005 - 0.012				
<b>ap Inch</b>	0.0197	0.0197				

### LEGEND

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

### FORMULA

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

**MILLING CARBIDE INSERT**

