



XNEX 040304 Z5



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 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	M30				
Sfm ft/min	594	374				
Fz Inch/Z	0.005 - 0.012	0.005 - 0.012				
ap Inch	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

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

MILLING CARBIDE INSERT