



XNEX 080608 Z21

APPLICATION

Double-sided milling insert, trigonal shape for a maximum depth of cut of .320". It is recommended for medium to heavy machining of steel, cast iron and stainless steel. It fits 600 milling cutters.



GRADE Z21

- This is a CVD TIN+ALN coated fine grained WC-Co carbide within ISO-grade ranges P25-P50 and M20-M40 for machining of steel and cast iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25		K20			
Sfm ft/min	594		561			
Fz Inch/Z	0.007 - 0.014		0.007 - 0.014			
ap Inch	0.0354		0.0354			

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT