



ADLX 1503 Z1

APPLICATION

- Suitable for steel and cast iron

GRADE Z1

It is a CVD coated WC-Co carbide within ISO-grade range P05-P25 for machining of steel and cast iron

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P15		K15			
Sfm ft/min	600-390		920-655			
Fn Inch/Z	.004-.008		.004-.010			
ap Inch	.039-.354		.039-.354			

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