



ADLX 1503 Z3

APPLICATION

- Suitable for steel machining steel



GRADE Z3

This grade has a submicron substrate without cubical carbide with a triple layer coating applied by CVD method. This grade is suitable for milling of materials group P, K, conditionally for M.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25-P50		P25-P50			
Sfm ft/min	920-655		920-655			
Fn Inch/Z	.004-.010		.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