



ADLX 1503 Z3F

APPLICATION

- Suitable for steel on manual milling machine

GRADE Z3F

It is a submicron grade without cubical carbides with low content of cobalt. This grade is for general purpose applications for all groups of work material except P. This grade is suitable for small up to medium chip cross section with steady cutting conditions.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25-P50					
Sfm ft/min	600-390					
Fn Inch/Z	.004-.008					
ap Inch	.039-.354					

LEGEND

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

FORMULA

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

MILLING CARBIDE INSERT