



APKT.PM 1604 Z1

APPLICATION

- Suitable for cast iron and hard steel
- It is an excellent grade for unstable cutting conditions with low up to medium cutting speed.



GRADE Z1

This is a MT-CVD coated WC-Co carbide for machining of cast iron and hard steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10-P30		K20 -K40			
Sfm ft/min	853 - 1115		804 - 1050			
Fn Inch/Z	.008-.014		.004 - .007			
ap Inch	.039-.512		.039 - .512			

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