



APKT.PM 1003 Z2



APPLICATION

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

GRADE Z2

This is a MT-CVD coated WC-Co carbide for machining of steel.

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P10-P30		K20 -K40			
Sfm ft/min	935 - 1329		886 - 1247			
Fn Inch/Z	.004-.010		.004 - .007			
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 (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